

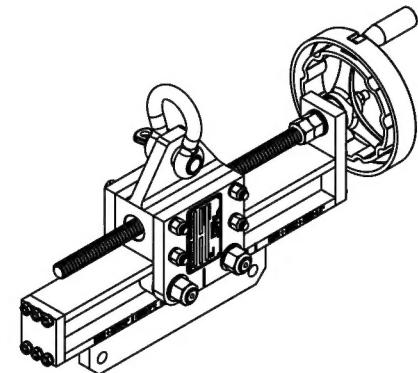
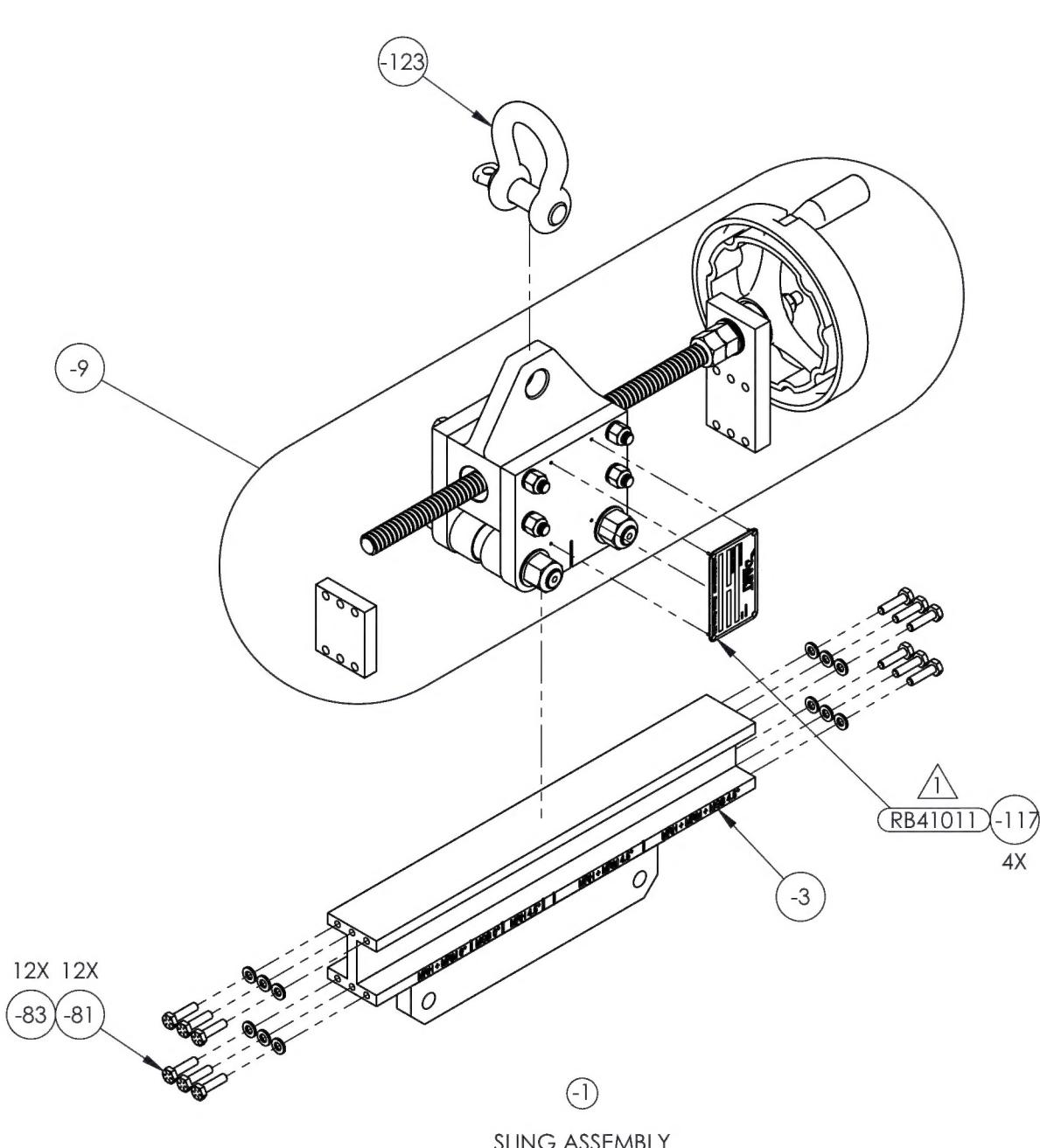
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ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.								
								X	-1	1	SLING ASSEMBLY			2	
								X	1	-3	BEAM WELDMENT			3	
								1		-5	BEAM	1018/1020 CR		4	
								1		-7	BEAM MOUNT BAR	1018/1020 CR		5	
								X	1	-9	SLING BLOCK/CRANK ASSY			6	
								X	1	-11	SLING BLOCK ASSEMBLY			7	
								1		-13	SLING BLOCK	1018/1020 CR		8	
								2		-15	SIDE PLATE	1018/1020 CR		9	
								1		-17	ACME SLEEVE NUT	BRONZE	5/8-8 (ROTON #89407) MODIFIED	10	
								1		-19	END PLATE	A36/1018/1020 HR		11	
								X	1	-21	CRANK END PLATE ASSEMBLY			12	
								1		-23	CRANK END PLATE	A36/1018/1020 HR		13	
								X	1	-25	ACME ROD ASSEMBLY			14	
								1		-27	ACME ROD	STEEL	5/8-8 X 14-3/4 (MCMASTER-CARR #93410A620) MODIFIED	15	
								1		-29	ACME ATTACHMENT	4140/4142		16	
								1		-31	HANDWHEEL	PLASTIC W/ STEEL HUB (CARRLANE #CL-62-HWAS-P) MODIFIED		17	
								X		-33	1 FRAME ASSEMBLY			18	
								X	1	-35	FRAME WELDMENT			19	
								1		-37	TUBE A	A500		20	
								1		-39	TUBE B	A500		21	
								1		-41	TUBE C	A500		22	
								1		-43	TUBE D	A500		23	
								3		-45	BUSHING	1018/1020 CR		24	
								1		-47	SMALL MOUNT BRACKET	A36/1018/1020 HR		25	
								1		-49	LONG MOUNT BRACKET	A36/1018/1020 HR		26	
								X	3	-51	CABLE ASSEMBLY			27	
1									B/O	-53	CABLE	STEEL	Ø5/16 X 30 (MCMASTER-CARR #3440T57)	27	
2									B/O	-55	LIFTING THIMBLE	STEEL	13/16 X 1-1/2, Ø5/16 ROPE (MCMASTER-CARR #3494T14)	27	
2									B/O	-57	COMPRESSION SLEEVE	COPPER	Ø5/16 ROPE (MCMASTER-CARR #3898T19)	27	
1									B/O	-59	HOIST RING	STEEL	12-13 X 1-1/16 X 4-7/8 (MCMASTER-CARR #3145T23)	27	
3									3	-61	LINK	4140/4142		16	
								4	B/O	-63	HEX HEAD CAP SCREW	STEEL GRD 8	3/8-24 X 4-1/4 (MCMASTER-CARR #91257A141)	26	
								8	1	B/O	-65	FLAT WASHER	STEEL	Ø3/8 (MCMASTER-CARR #95229A490)	25
								4	1	B/O	-67	NYLON-INSERT LOCKNUT	STEEL	3/8-24 (MCMASTER-CARR #97135A235)	27
								8		B/O	-69	POINT SET SCREW	STEEL	1/4-28 X 1/4 (MCMASTER-CARR #92695A311)	7
								4		B/O	-71	TRACK ROLLER	STEEL	5/8-18 X 3/4 X 1-1/2 STUD X Ø1-1/2 X 7/8 (MCMASTER-CARR #3652K23)	7
								4		B/O	-73	FLAT WASHER	STEEL	Ø5/8 (MCMASTER-CARR #95229A610)	7
								4		B/O	-75	NYLON-INSERT LOCKNUT	STEEL	5/8-18 (MCMASTER-CARR #97135A275)	7
								1		B/O	-77	NEEDLE ROLLER BEARING	STEEL	Ø5/8 I.D. X Ø13/16 O.D. X 5/8 (MCMASTER-CARR #5905K25)	12
								12	B/O	-81	HEX HEAD CAP SCREW	STEEL	1/4-28 X 1 (MCMASTER-CARR #92620A564)	2	
								12	B/O	-83	FLAT WASHER	STEEL	Ø1/4 (MCMASTER-CARR #95229A430)	2	
								2	B/O	-85	THRUST NEEDLE BEARING	STEEL	Ø5/8 I.D. X Ø1-1/8 O.D. X 5/64 (MCMASTER-CARR #5909K32)	2	
								4	B/O	-87	THRUST BEARING WASHER	STEEL	Ø5/8 I.D. X Ø1-1/8 O.D. X .032 (MCMASTER-CARR #5909K45)	2	
								2	B/O	-89	ACME NUT	S.S.	5/8-8 ACME THREAD (MCMASTER-CARR #95066A213)	2	
								1	B/O	-91	SQUARE KEY	STEEL	1/8 X 1 (MCMASTER-CARR #98870A110)	2	
3								3	B/O	-93	QUICK RELEASE PIN	S.S.	ØM12 X 50mm USABLE (MCMASTER-CARR #93871A880)	18	
3								3	B/O	-95	HEX HEAD CAP SCREW	STEEL	3/8-16 X 2-1/4 (MCMASTER-CARR #91257A633)	18	
6								B/O	-97	FLAT WASHER	STEEL	Ø3/8 (MCMASTER-CARR #98023A031)	18		
3								B/O	-99	NYLON INSERT LOCKNUT	STEEL	3/8-16 (MCMASTER-CARR #97135A230)	18		
4								B/O	-101	HEX HEAD CAP SCREW	STEEL	1/2-13 X 4 (MCMASTER-CARR #91257A728)	18		
2								B/O	-103	HEX HEAD CAP SCREW	STEEL	1/2-13 X 2-1/4 (MCMASTER-CARR #91257A721)	18		
12								B/O	-105	FLAT WASHER	STEEL	Ø1/2 (MCMASTER-CARR #98023A033)	18		
6								B/O	-107	NYLON-INSERT LOCKNUT	STEEL	1/2-13 (MCMASTER-CARR #97135A250)	18		
3									-109	TUBE CAP	A36/1018/1020 HR		29		
3								B/O	-115	CABLE TAB	ALUMINUM	(CARR LANE CL-129-TAB-A)		18	
3								4	B/O	-117	#2 DRIVE SCREW	STEEL	#2 X 1/4 (MCMASTER-CARR #90081A077)	18	
3								B/O	-119	LANYARD	COATED STEEL	Ø1/16 X 10 (CARR LANE #CL-2-C)	N/S		
6								B/O	-121	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	N/S		
								1	B/O	-123	SCREW PIN SHACKLE	S.S.	Ø3/4 PIN 2 TON (MCMASTER-CARR #3583T16)	2	
1								B/O	-125	DECAL	BLACK VINYL	(SIGNS NOW)		30	
								1	B/O	DART PLACARD	ALUMINUM	RB41011		2	
ASSY -51	ASSY -35	ASSY -33	ASSY -25	ASSY -21	ASSY -11	ASSY -9	ASSY -3	ASSY -1							

REVISIONS		
REV	ECR	DESCRIPTION
1		RELEASED FOR PRODUCTION
2	16-0221	<p>-1 ADDED -123 QTY 1 & -117 QTY 4 TO ASSEMBLY. DELETED -65, -67, -85, -87, -89, -91, -111, -113 FROM ASSEMBLY. -3 CH'D NOTE FROM FILL W/ BLACK INK TO FILL W/ RED PAINT. -9 ADDED -65, -67, -85, -89, -91 TO ASSEMBLY. -13 CH'D DIMS FROM Ø.755 THRU ALL Ø.80 X 90° BOTH SIDES TO Ø.875 THRU ALL Ø.98 X 90° BOTH SIDES. FROM Ø1.126-1.129 THRU ALL Ø1.18 X 90° BOTH SIDES TO Ø1.125-1.129 THRU ALL Ø1.18 X 90° BOTH SIDES. -9 ADDED -65, -67, -85, -87, -89, -91 ADDED TO ASSEMBLY. -15 CH'D DIM WAS 3.525 IS 2X 3.525. ADDED DIMS 2X .91, 2X 1.704, 2X .28, 2X 2.954, 4X Ø.086 V.31, .97, 2.360. DELETED DIM 2.323. -19 ADDED DIM 2X .61. CH'D MATL FROM 1018/1020 CR TO A36/1018/1020 HR. -23 CH'D MATL FROM 1018/1020 CR TO A36/1018/1020 HR. -25 DELETED -79 FROM ASSEMBLY. ADDED WELD SYMBOL. ADDED FINISH ZINC PLATE ASTM B633 TYPE I SC2 TO SEE -25. -27 DELETED DIMS .365, Ø.1869-1874 THRU ALL (P.F. -79). CH'D FINISH FROM ZINC PLATE ASTM B633 TYPE I SC2 IS SEE -25. -33 CORRECTED ORIENTATION OF -35. ADDED -125 DECAL TO ASSY. -35 ADDED WELD SYMBOLS. CH'D DIM WAS 2.675 IS (2.675). ADDED -109 TO ASSY. -37, -41, -43 CH'D MATL WAS A36/1018/1020 HR IS A500. -61 CH'D MATL WAS 1018/1020 CR IS 4140/4142. ADDED DIM 1.47±.05. CH'D DIMS WAS .508 IS .51, WAS Ø.095-0.098 V.15 IS Ø.086 V.31. -79 DELETED FROM BOM. -109 ADDED DRAWING. CH'D MATL WAS POLYETHYLENE IS A36/1</p>

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221					-1 ADDED -123 QTY 1 & -117 QTY 4 TO ASSEMBLY. DELETED -65, -67, -85, -87, -89, -91, -111, -113 FROM ASSEMBLY.						11/15/2016	DPD	JAG			



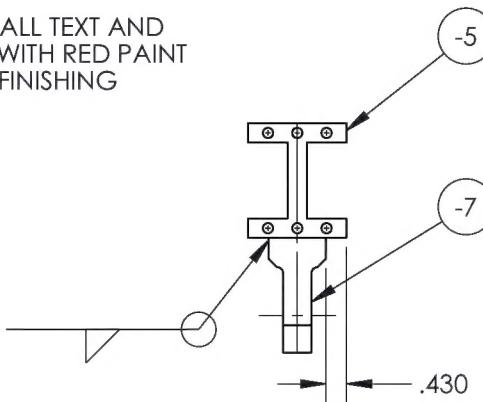
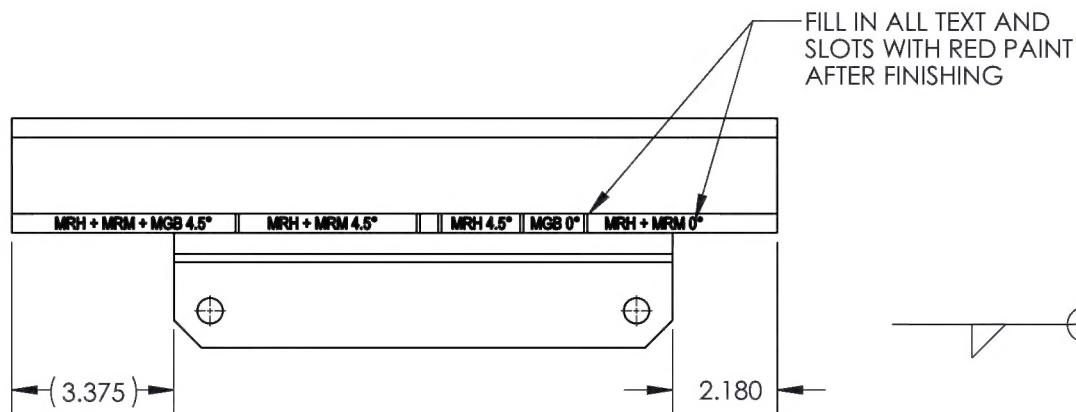
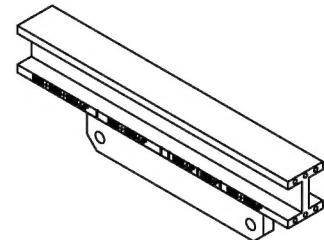
NOTE:

1 ENGRAVE PLACARD (RB41011) WITH T/N, S/N, "MADE IN USA" AND "SAFE WORKING LOAD 2039 LBS/925 KG".

DART AEROSPACE																													
TITLE																													
MAIN ROTOR HEAD SLING																													
DWG NO. RBEM622U1005103-1 REV 2																													
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">MATERIAL</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>HEAT</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>TREAT</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td>FINISH</td> <td>X ± .1 SURFACES = 125</td> </tr> <tr> <td>SPEC</td> <td></td> </tr> <tr> <td>DRAWN BY:</td> <td>CLOUGH</td> </tr> <tr> <td>CHECKED:</td> <td>MACKOVJAK</td> </tr> <tr> <td>OPPS APPR:</td> <td>ANDERSON</td> </tr> <tr> <td>QA APPR:</td> <td>LINDSAY</td> </tr> <tr> <td>APPROVED:</td> <td>GILBERT</td> </tr> <tr> <td>USED ON MODEL</td> <td>H175</td> </tr> <tr> <td>SCALE</td> <td>1:5</td> </tr> <tr> <td>DATE</td> <td>5/13/2016</td> </tr> <tr> <td colspan="2">SHEET 2 OF 31</td> </tr> </table>		MATERIAL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	HEAT	.XXX ± .005 FRACTIONS ± 1/8	TREAT	.XX ± .01 ANGLES ± 5°	FINISH	X ± .1 SURFACES = 125	SPEC		DRAWN BY:	CLOUGH	CHECKED:	MACKOVJAK	OPPS APPR:	ANDERSON	QA APPR:	LINDSAY	APPROVED:	GILBERT	USED ON MODEL	H175	SCALE	1:5	DATE	5/13/2016	SHEET 2 OF 31	
MATERIAL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES																												
HEAT	.XXX ± .005 FRACTIONS ± 1/8																												
TREAT	.XX ± .01 ANGLES ± 5°																												
FINISH	X ± .1 SURFACES = 125																												
SPEC																													
DRAWN BY:	CLOUGH																												
CHECKED:	MACKOVJAK																												
OPPS APPR:	ANDERSON																												
QA APPR:	LINDSAY																												
APPROVED:	GILBERT																												
USED ON MODEL	H175																												
SCALE	1:5																												
DATE	5/13/2016																												
SHEET 2 OF 31																													

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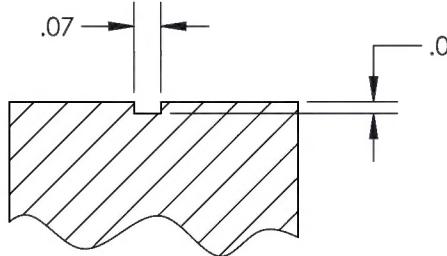
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-3 CH'D NOTE FROM FILL W/ BLACK INK TO FILL W/ RED PAINT.	11/15/2016	DPD	JAG



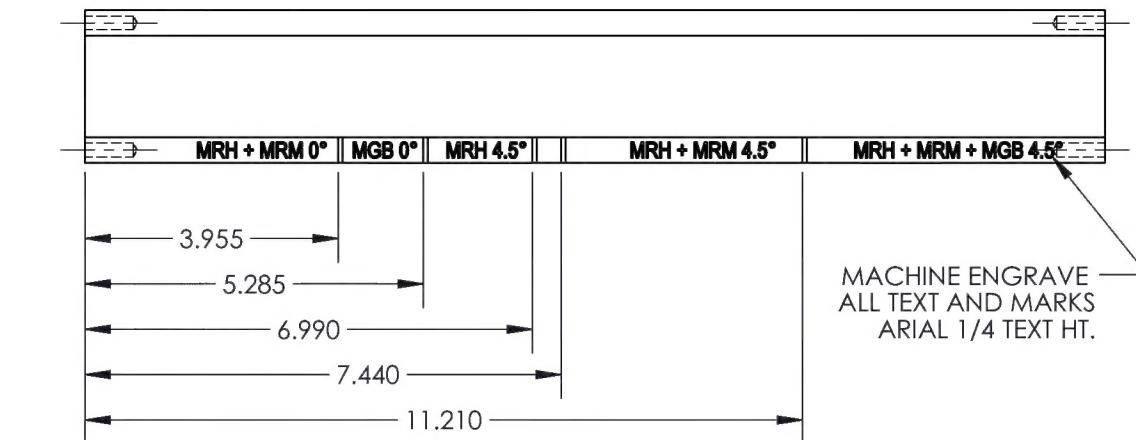
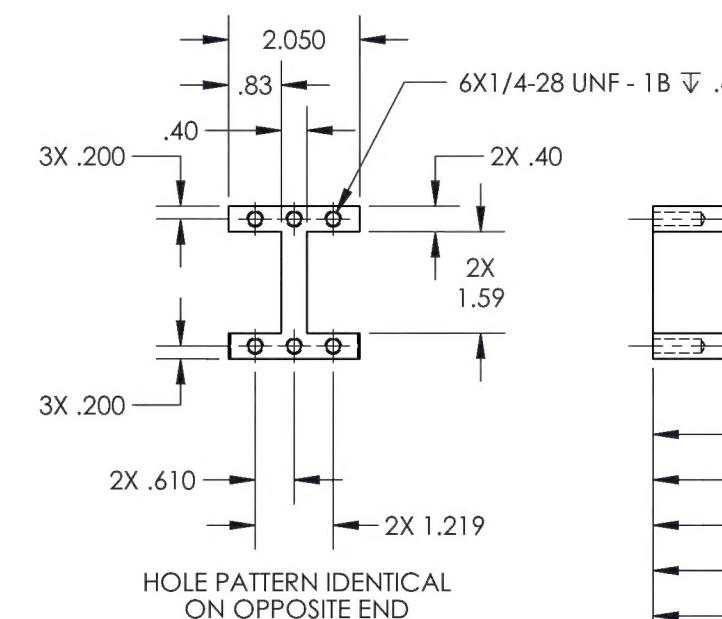
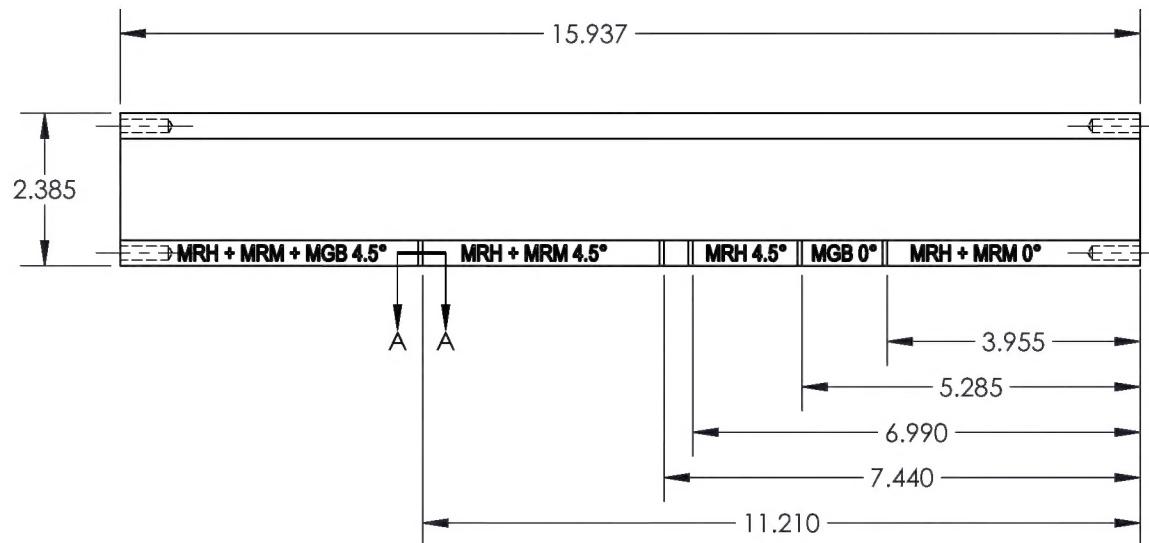
(3)

BEAM WELDMENT

DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-3	
REV 2	
MATERIAL	
HEAT	
TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE 1:4	DATE 5/13/2016
SHEET 3 OF 31	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	



SECTION A-A
SCALE 2 : 1
10 PLACES

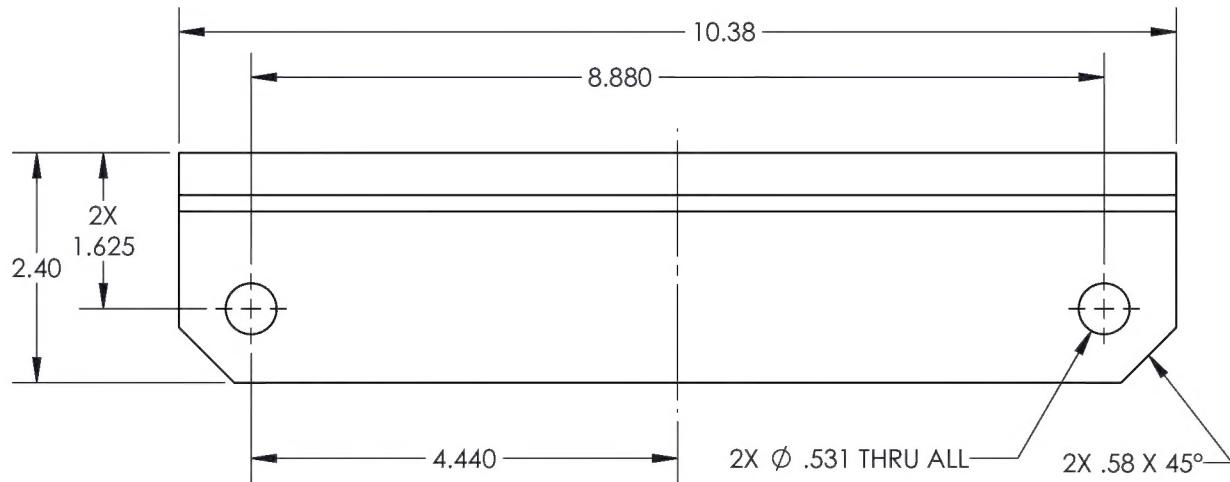
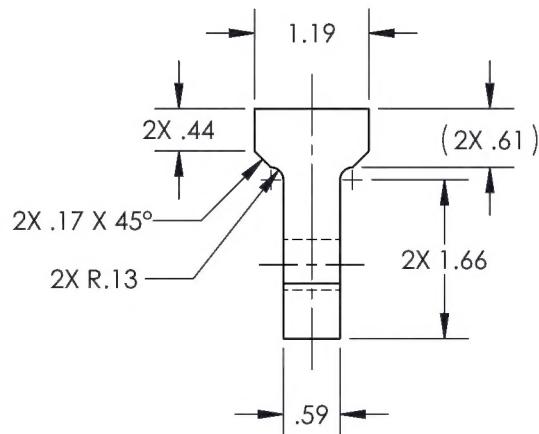
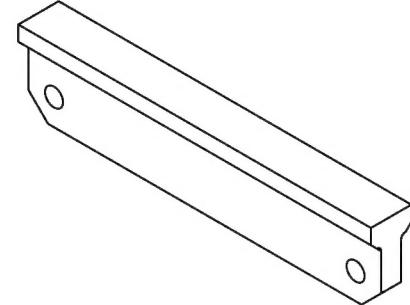


(-5)
BEAM

DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-5
REV	2
MATERIAL 1018/1020 CR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.005 FRACTIONS \pm 1/8	
HEAT	XXX \pm .005
TREAT	XX \pm .01
FINISH	ANGLES \pm 5°
SEE -3	
X \pm .1 SURFACES = 125	
SPEC	
1. BREAK ALL SHARP EDGES	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:3
DATE	5/13/2016
SHEET 4 OF 31	

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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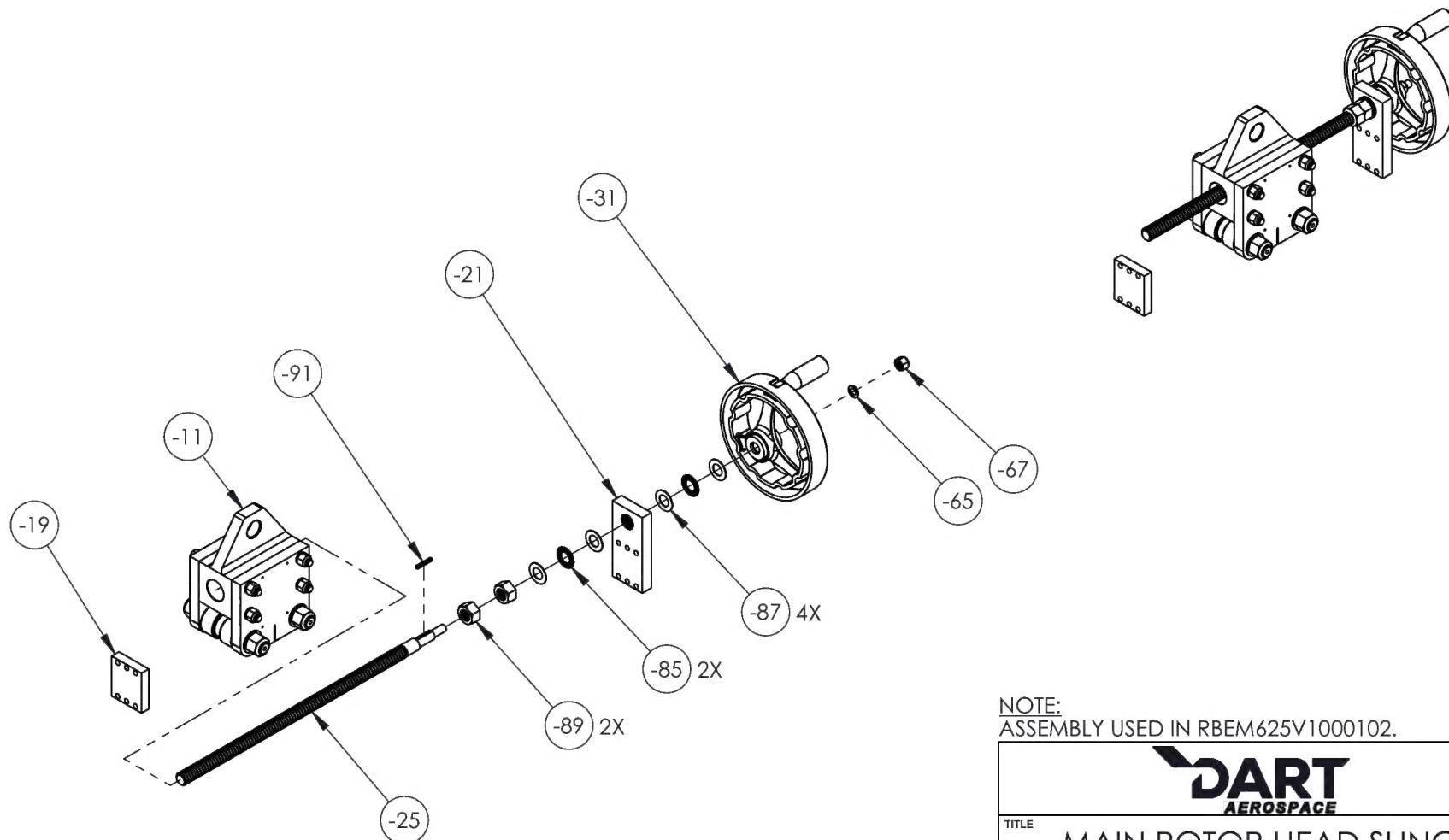
DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	
RBEM622U1005103-7	
REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:2
DATE	5/13/2016
SHEET 5 OF 31	

(-7)

BEAM MOUNT BAR

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221		-9 ADDED -65, -67, -85, -87, -89, -91 TO ASSEMBLY.						11/16/2016			DPD			JAG		



NOTE:
ASSEMBLY USED IN RBEM625V1000102.



TITLE
MAIN ROTOR HEAD SLING

DWG NO. RBEM622U1005103-9

REV 2

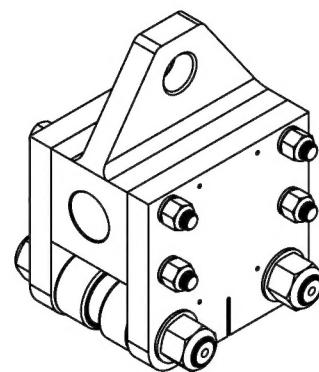
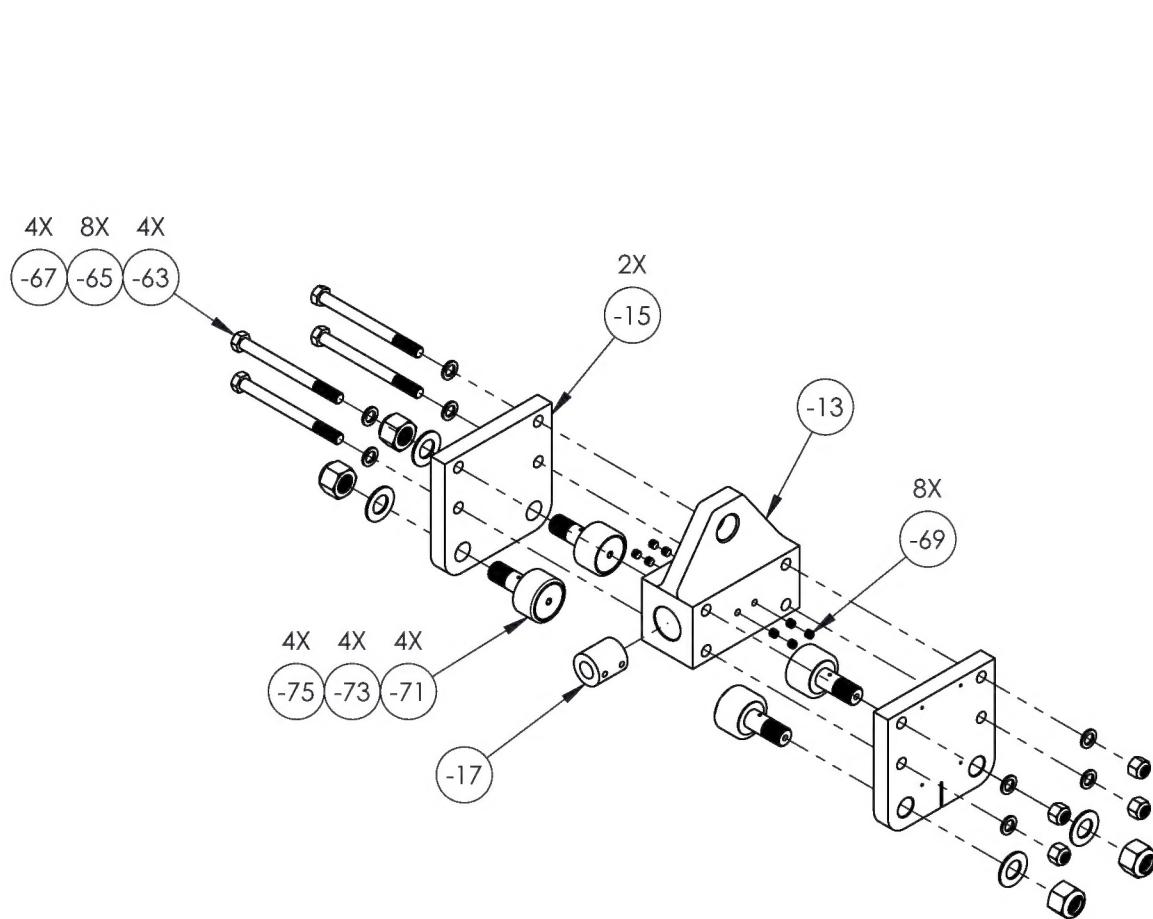
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX	± .005 FRACTIONS ± 1/8
TREAT	.XX	± .01 ANGLES ± 5°
FINISH	X	± .1 SURFACES = 125
SPEC		
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	LINDSAY	USED ON MODEL
APPROVED:	GILBERT	H175
SCALE	1:8	DATE 5/13/2016
		SHEET 6 OF 31

SLING BLOCK/CRANK ASSY

(-9)

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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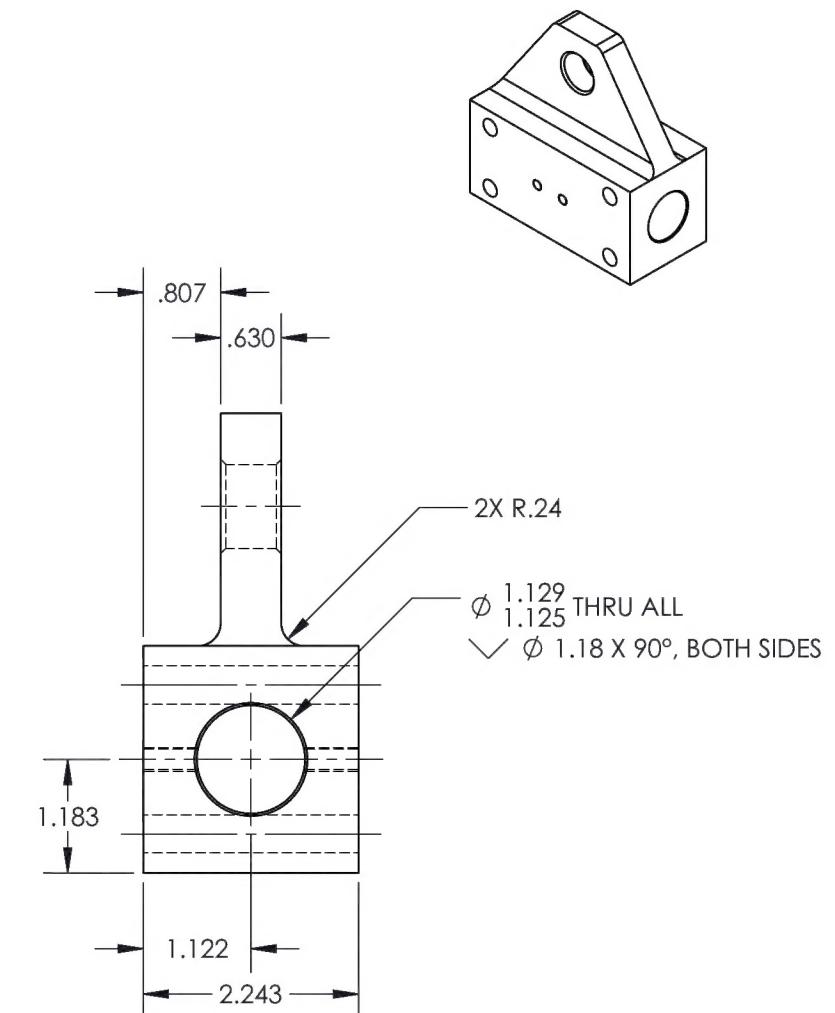
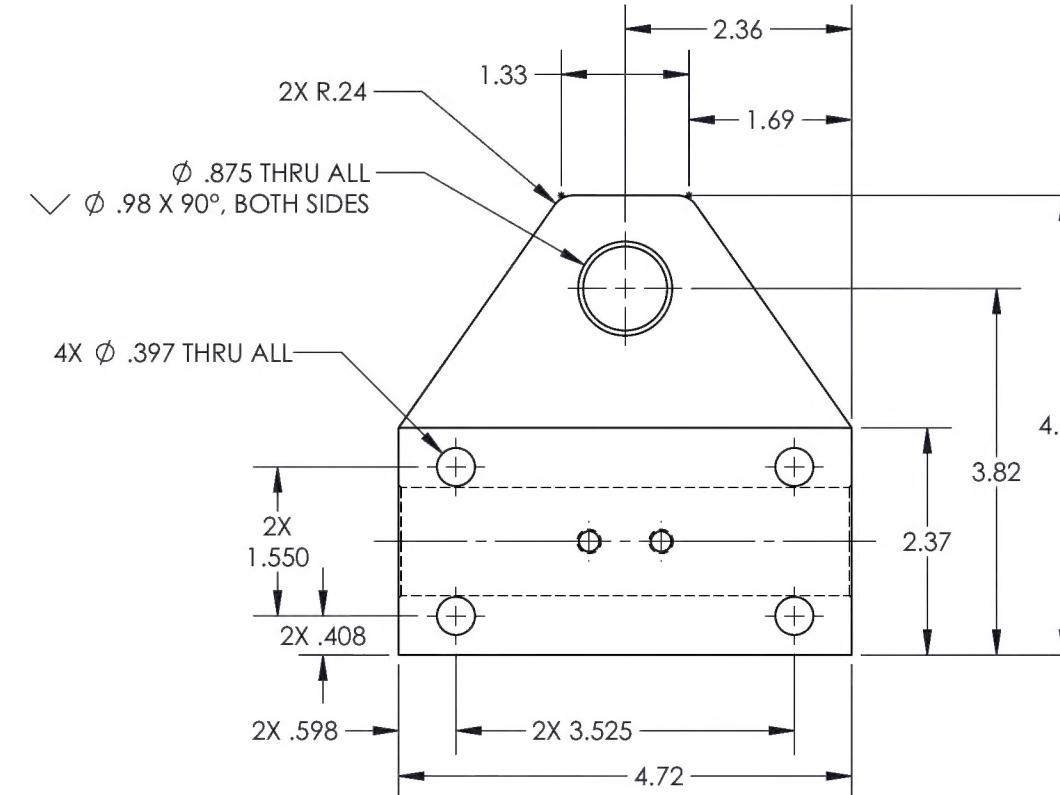
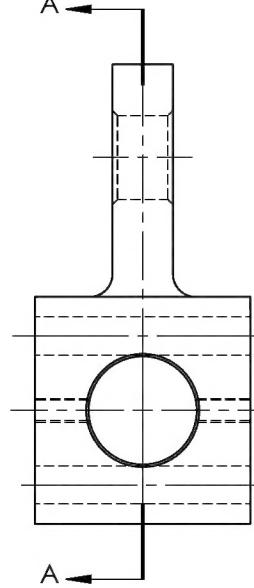
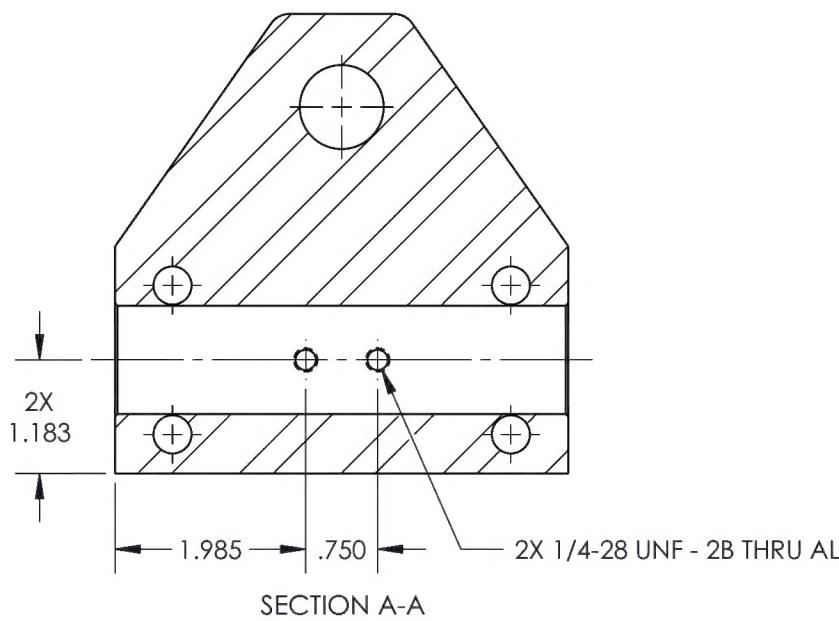


SLING BLOCK ASSEMBLY

(-11)

DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-11	
REV 2	
MAT'L UNLESS OTHERWISE SPECIFIED HEAT DIMENSIONS ARE IN INCHES TREAT .XXX ± .005 FRACTIONS ± 1/8 FINISH .XX ± .01 ANGLES ± 5° SPEC .X ± .1 SURFACES = 125 ✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:6
DATE	5/13/2016
SHEET 7 OF 31	

REV		ECR	DESCRIPTION		DATE	INITIAL	APPROVED
2	16-0221		-13	CH'D DIMS FROM \emptyset .755 THRU ALL \checkmark \emptyset .80 X 90°. BOTH SIDES TO \emptyset .875 THRU ALL \checkmark \emptyset .98 X 90° BOTH SIDES, FROM \emptyset 1.126-1.129 THRU ALL \checkmark \emptyset 1.18 X 90°. BOTH SIDES TO \emptyset 1.125-1.129 THRU ALL \checkmark \emptyset 1.18 X 90°, BOTH SIDES.	11/15/2016	DPD	JAG



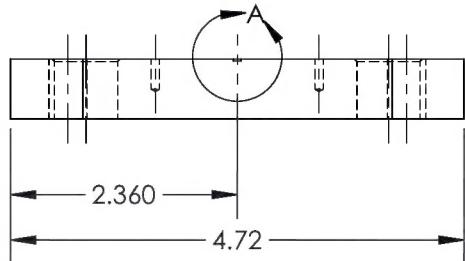
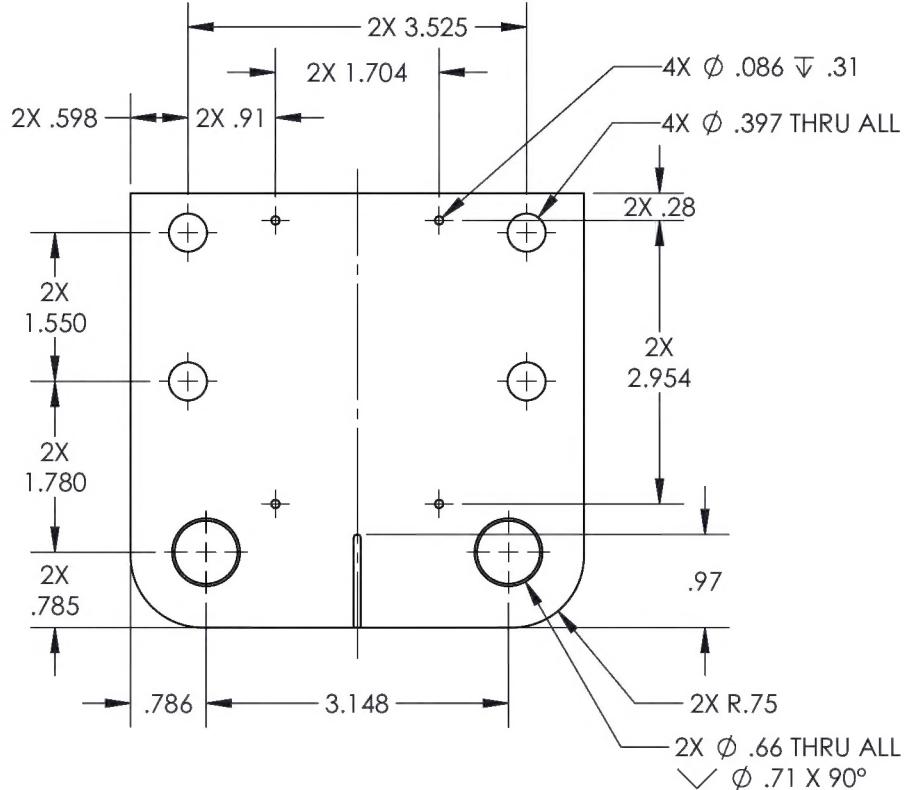
SLING BLOCK

-13

DART	
AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-13
REV	2
MATERIAL 1018/1020 CR	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.005 ± .005 FRACTIONS ± 1/8	
.005 ± .01 ANGLES ± 5°	
.005 ± .1 SURFACES = 125	
HEAT TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:2
DATE	5/13/2016
SHEET 8 OF 31	

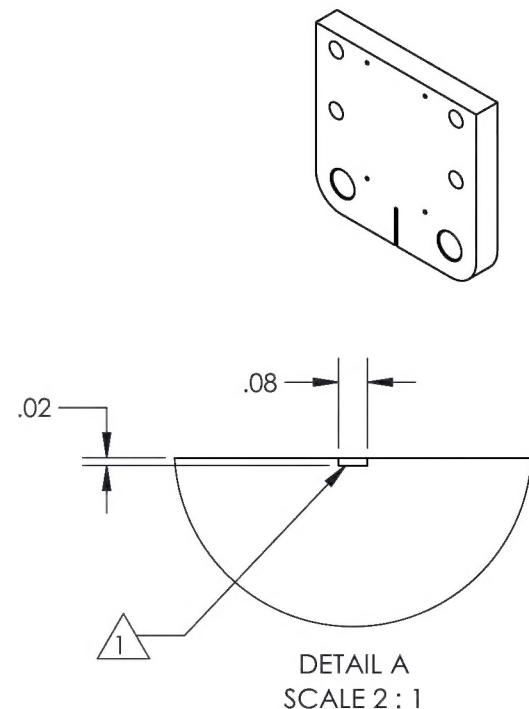
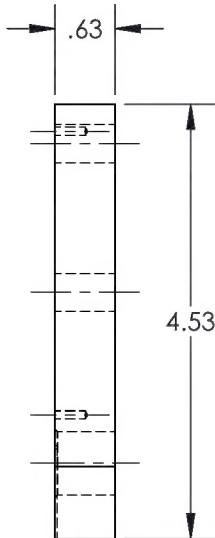
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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221					-15 CH'D DIM WAS 3.525 IS 2X 3.525. ADDED DIMS 2X .91, 2X 1.704, 2X .28, 2X 2.954, 4X Ø .086 T.31, .97, 2.360. DELETED DIM 2.323.							11/15/2016	DPD	DPD		



SIDE PLATE

(-15)



DETAIL A
SCALE 2 : 1

NOTE:

1 MACHINE ENGRAVE CENTERING MARK. FILL CENTERING MARK WITH BLACK PAINT.



TITLE
MAIN ROTOR HEAD SLING

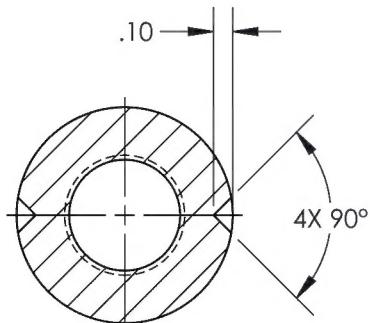
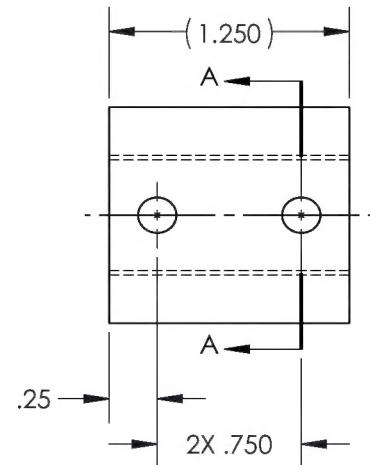
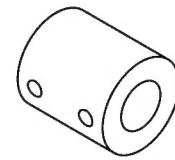
DWG NO. RBEM622U1005103-15

REV 2

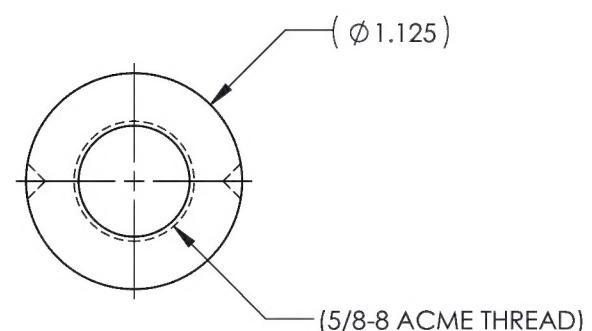
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 5/13/2016
	SHEET 9 OF 31

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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SECTION A-A



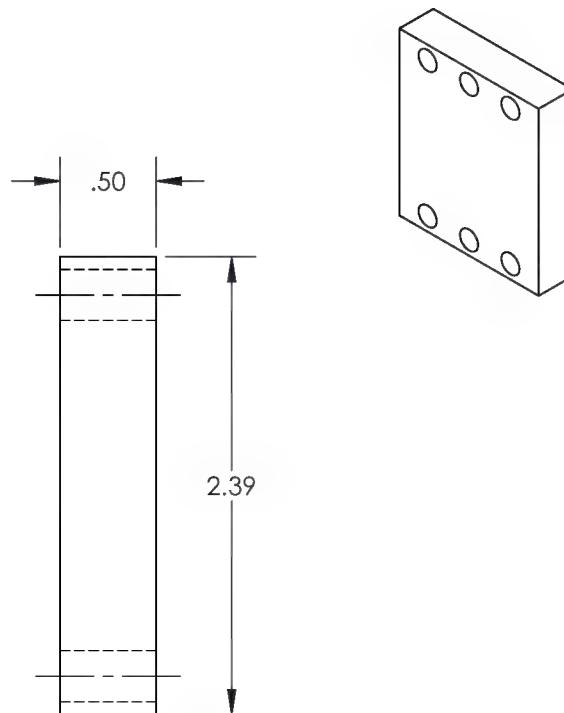
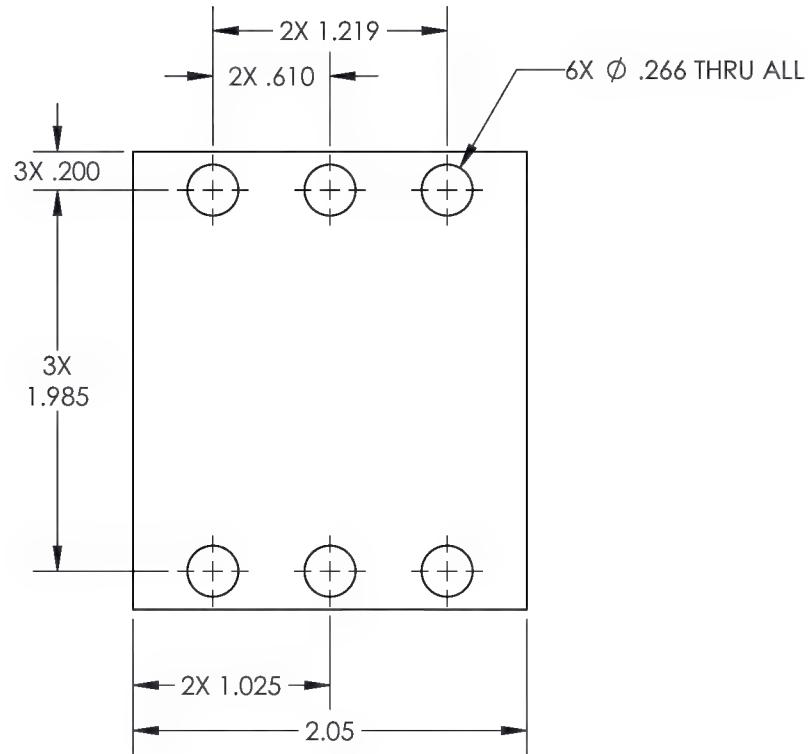
ACME SLEEVE NUT

-17

	
TITLE	MAIN ROTOR HEAD SLING
DWG NO.	RBEM622U1005103-17
REV	2
MAT'L	BRONZE
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:1
DATE	5/13/2016
SHEET	10 OF 31

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221		-19 ADDED DIM 2X .610. CH'D MAT'L FROM 1018/1020 CR TO A36/1018/1020 HR.						11/15/2016			DPD			JAG		



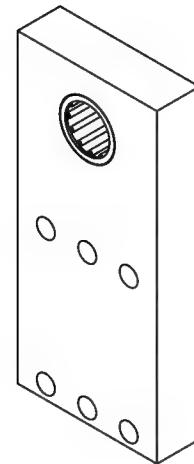
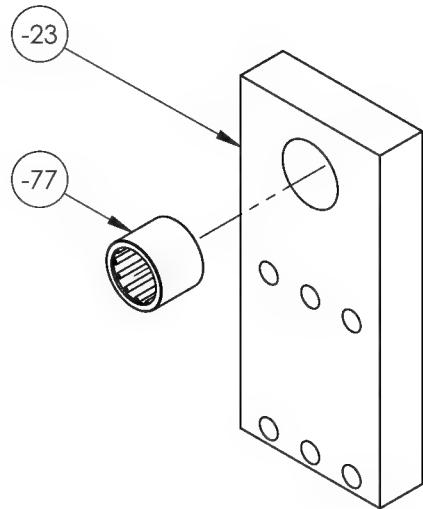
END PLATE

-19

	
TITLE MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-19
REV	2
MAT'L	A36/1018/1020 HR
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005
TREAT	FRACTIONS ± 1/8
FINISH	.XX ± .01
	ANGLES ± 5°
SPEC	.X ± .1
ZINC PLATE	
SPEC	SURFACES = 125 ✓
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL H175	
SCALE	1:1
DATE	5/13/2016
SHEET 11 OF 31	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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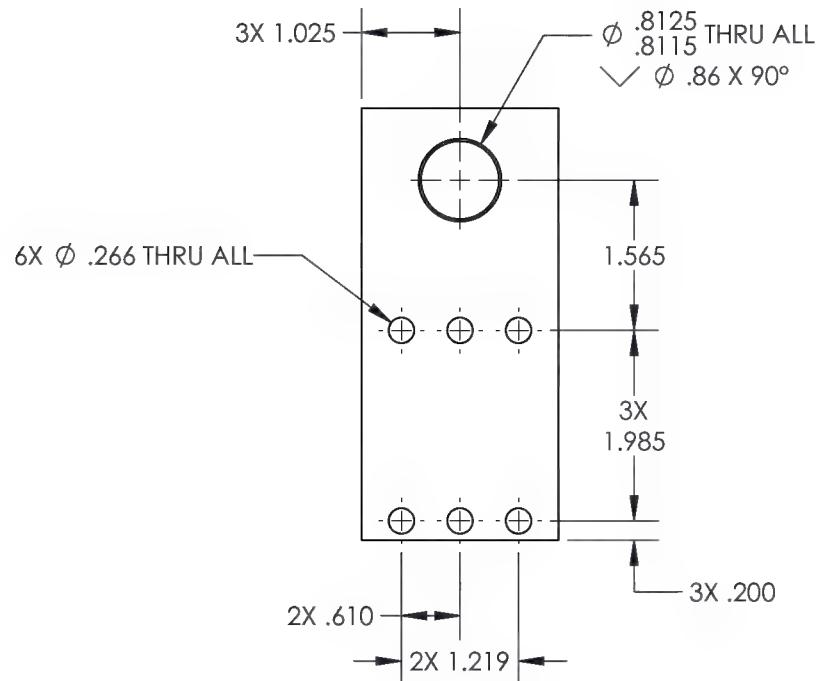
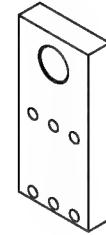
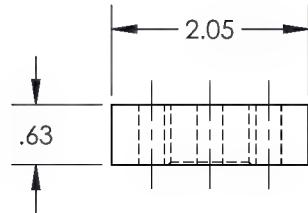
CRANK END PLATE ASSEMBLY

(-21)

DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-21 REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	5/13/2016
SHEET 12 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-23 CH'D MAT'L FROM 1018/1020 CR TO A36/1018/1020 HR.	11/15/2016	DPD	JAG



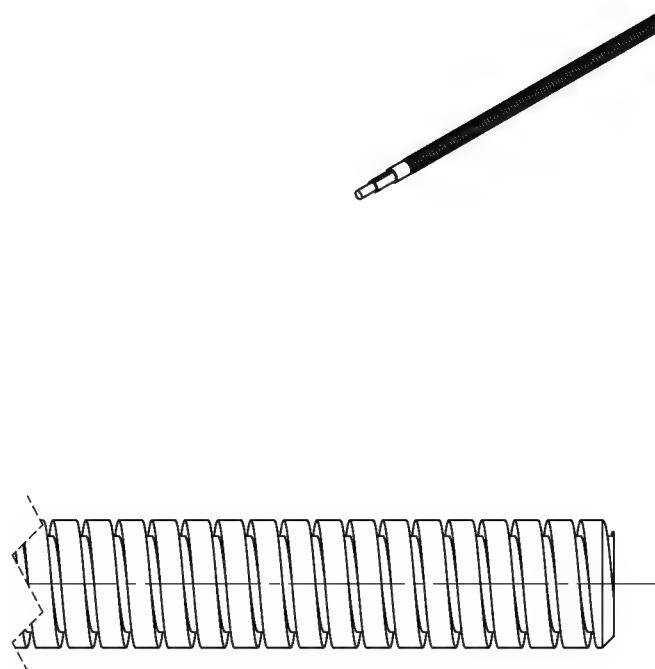
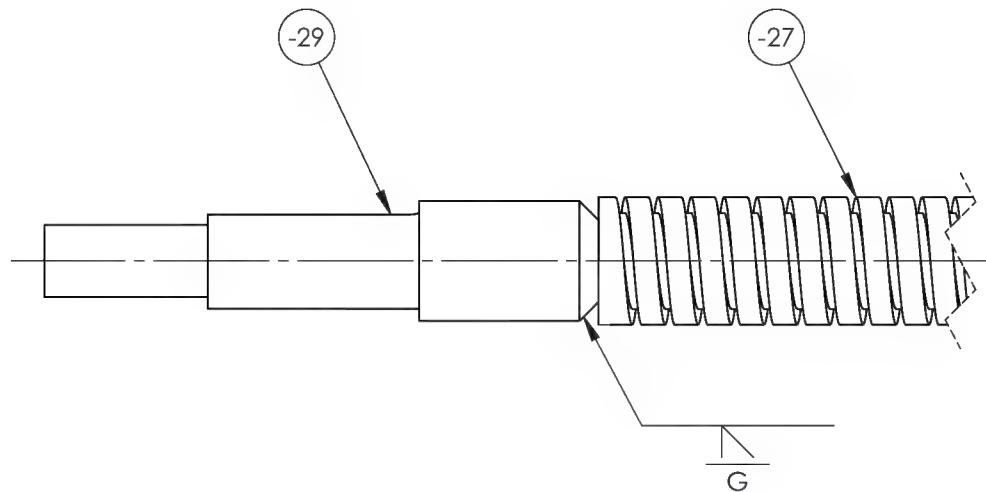
(-23)

CRANK END PLATE

DART AEROSPACE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-23
REV	2
MAT'L	A36/1018/1020 HR
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	5/13/2016
SHEET	13 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-25 DELETED -79 FROM ASSEMBLY. ADDED WELD SYMBOL. ADDED FINISH ZINC PLATE ASTM B633 TYPE I SC2.	11/15/2016	DPD	JAG



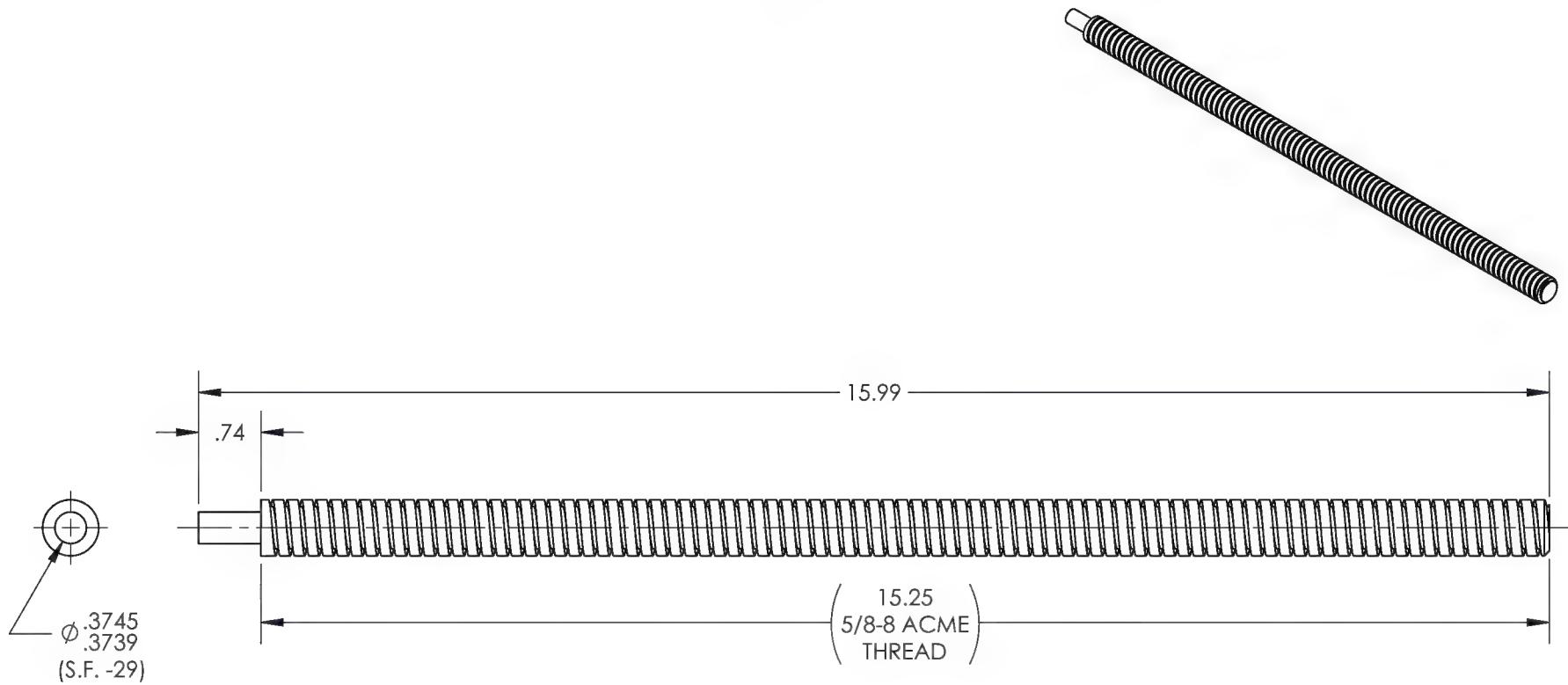
-25

ACME ROD ASSEMBLY

DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-25
REV	2
MATERIAL	
HEAT TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
H175	
SCALE	1:1
DATE	5/13/2016
SHEET 14 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-27 DELETED DIMS .365, Ø.1869-.1874 THRU ALL (P.F. -79). CH'D FINISH FROM ZINC PLATE ASTM B633 TYPE 1 SC2 TO SEE -25.	11/15/2016	DPD	JAG



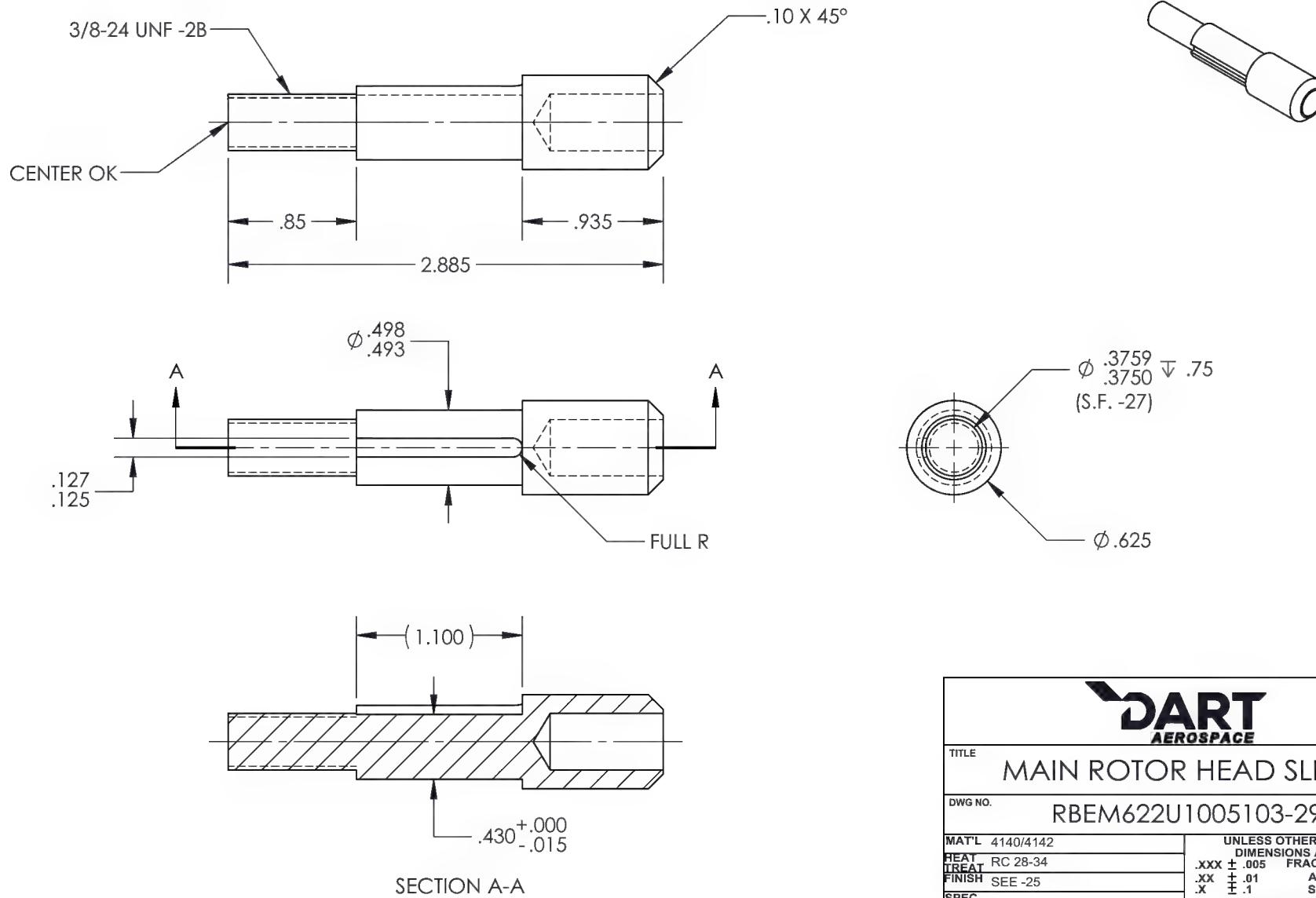
-27

ACME ROD

DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-27
REV	2
MATERIAL STEEL	
HEAT	
TREAT	
FINISH SEE -25	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:2
DATE	5/13/2016
SHEET 15 OF 31	

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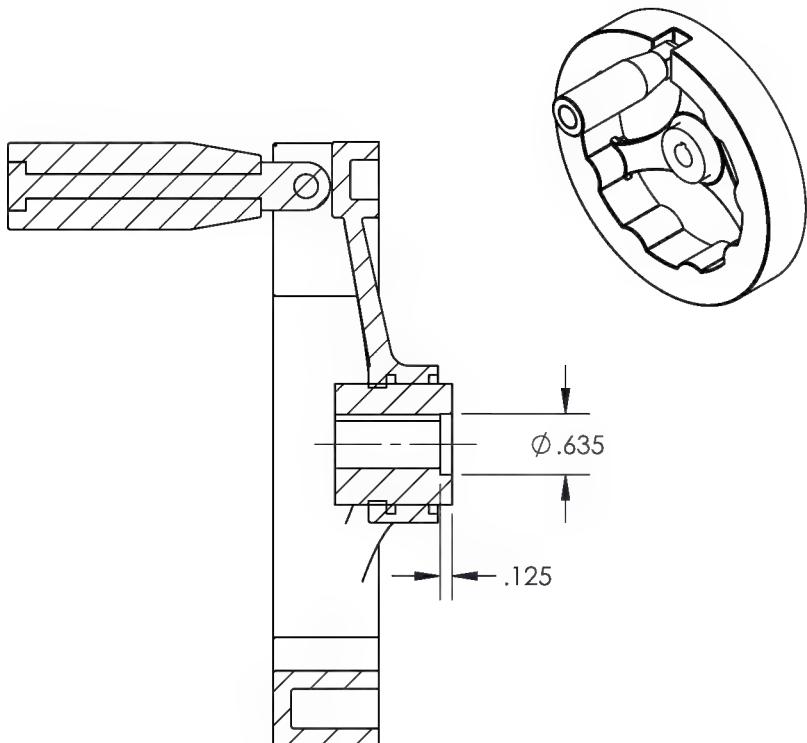
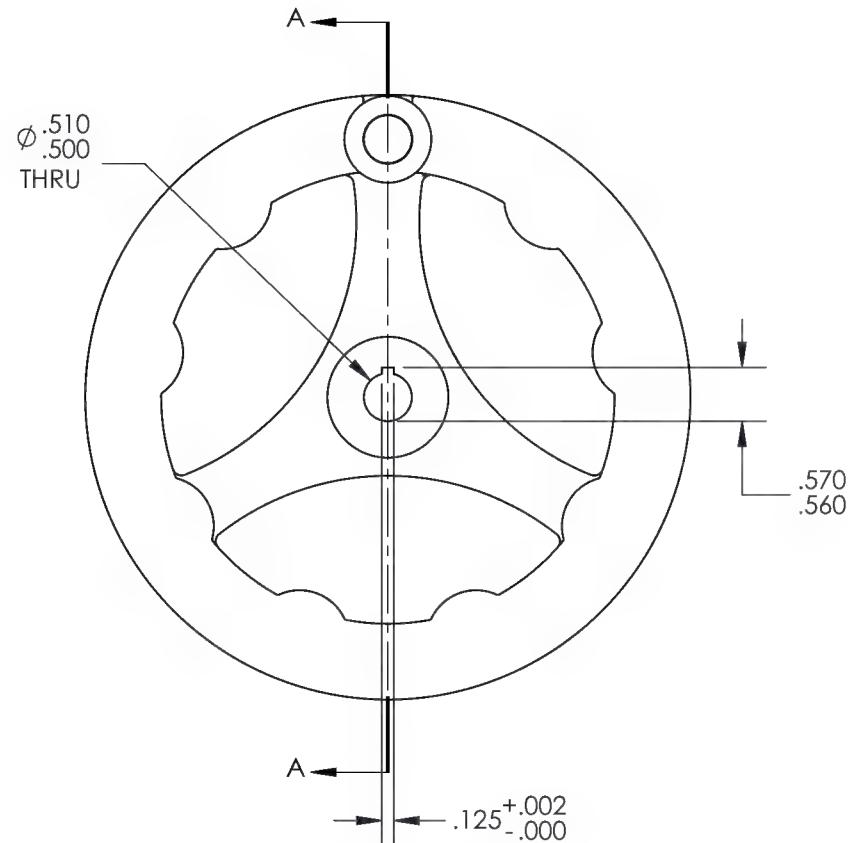
			REVISIONS			
REV	ECR		DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221		-29 DELETED DIMS .375, Ø.1890-.1902 THRU ALL (S.F. -79). ADDED DIM .10 X 45°. CH'D MAT'L FROM 4140 Q&T/4142 Q&T TO 4140/4142. CH'D FINISH WAS ZINC PLATE ASTM B633 TYPE I SC2 SEE -25.	11/15/2016	DPD	JAG



DART	
AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-29
MAT'L	4140/4142
HEAT	RC 28-34
TREAT	
FINISH	SEE -25
SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125 ✓
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:1
DATE	5/13/2016
SHEET 16 OF 31	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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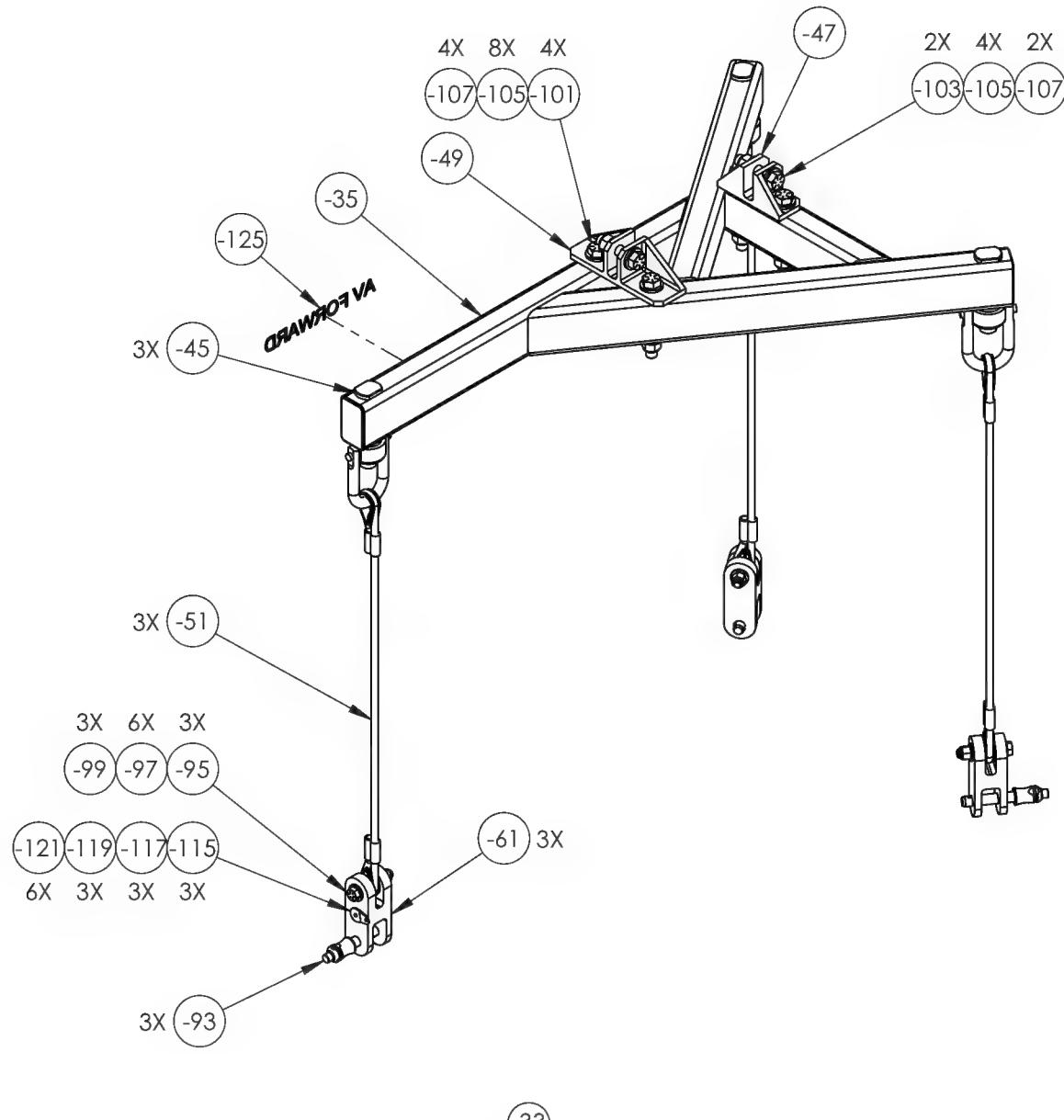
HANDWHEEL

(-31)

TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-31
REV	2
MATERIAL: PLASTIC W/ STEEL HUB	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125 ✓
SPEC	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
AGUSTA AW139	
SCALE	1:2
DATE	5/13/2016
SHEET 17 OF 31	

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221		-33 CORRECTED ORIENTATION OF -35. ADDED -125 DECAL TO ASSY.						1/4/2017			DPD			JAG		



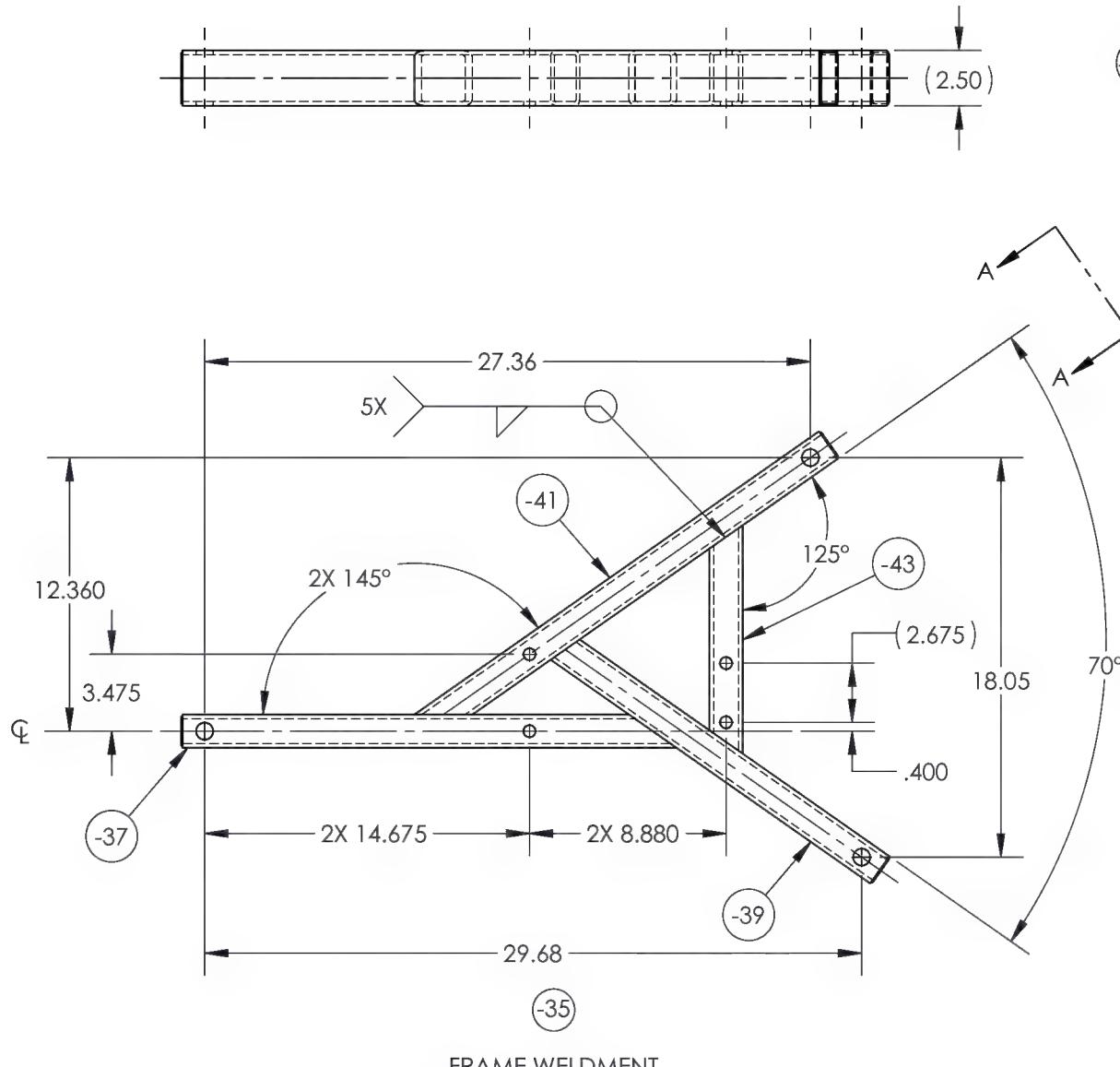
FRAME ASSEMBLY

DART AEROSPACE	
MAIN ROTOR HEAD SLING	
TITLE	
DWG NO.	RBEM622U1005103-33
REV	2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	X ± .1 SURFACES = 125 ✓
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:8
DATE	5/13/2016
SHEET	18 OF 31

-33

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221		-35 ADDED WELD SYMBOLS. CH'D DIM WAS 2.675 IS (2.675). ADDED -109 TO ASSY.						11/15/2016			DPD			JAG		



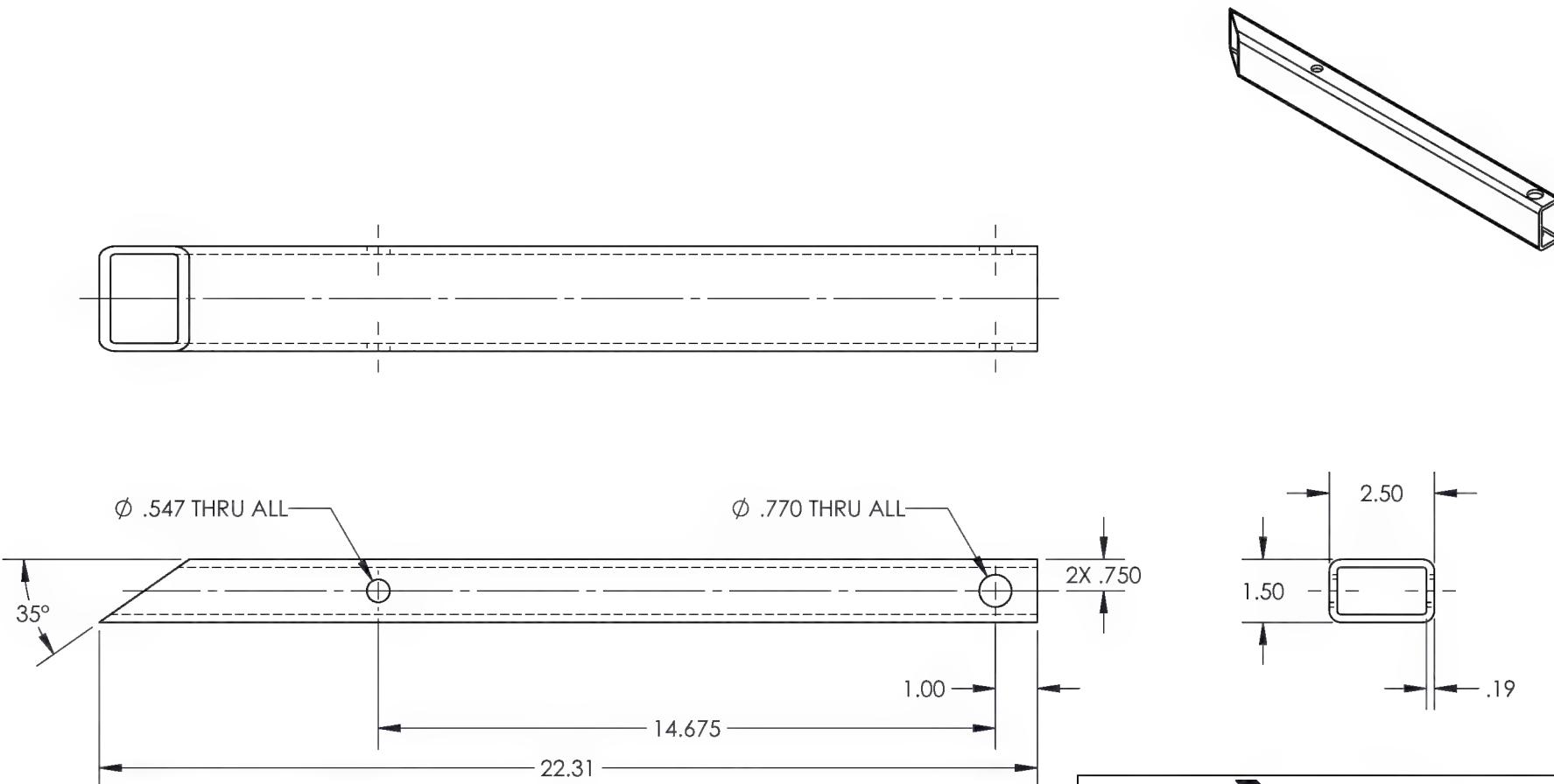
DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-35	
REV 2	
MAT'L	
HEAT	
TREAT	
FINISH POWDER COAT YELLOW	
SPEC FED #13538	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:8
DATE	5/13/2016
SHEET 19 OF 31	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
.X ± .1 SURFACES = 125 ✓

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221		-37 CH'D MAT'L WAS A36/1018/1020 HR IS A500.						11/15/2016			DPD			JAG		



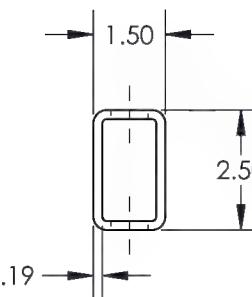
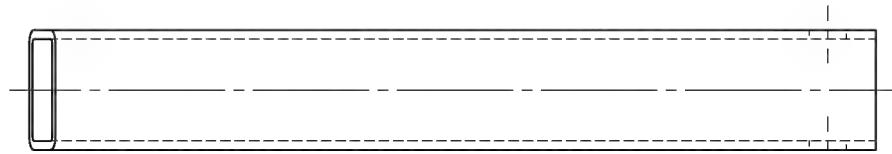
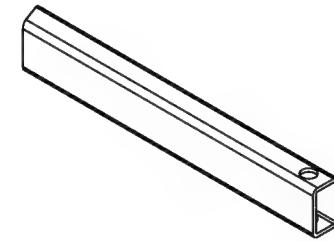
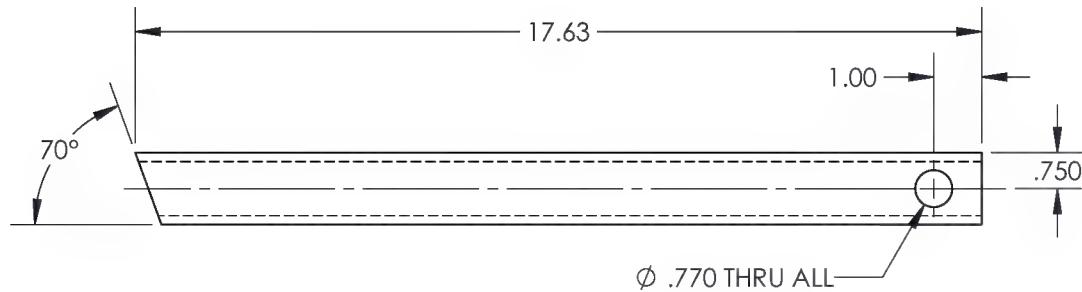
(-37)

TUBE A

	
TITLE MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-37
REV	2
MAT'L A500 UNLESS OTHERWISE SPECIFIED HEAT DIMENSIONS ARE IN INCHES TREAT .XXX ± .010 FRACTIONS ± 1/8 FINISH SEE -35 .XX ± .03 ANGLES ± 1° SPEC X ± .1 SURFACES = 125 ✓	
DRAWN BY: CLOUGH 1. BREAK ALL SHARP EDGES CHECKED: MACKOVJAK .015 x 45° OR .015R OPPS APPR: ANDERSON 2. DIMENSIONAL LIMITS APPLY QA APPR: LINDSAY AFTER PLATING APPROVED: GILBERT 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL H175	
SCALE	1:4
DATE	5/13/2016
SHEET 20 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-39 CH'D MAT'L FROM A36/1018/1020 HR TO A500.	11/15/2016	DPD	JAG



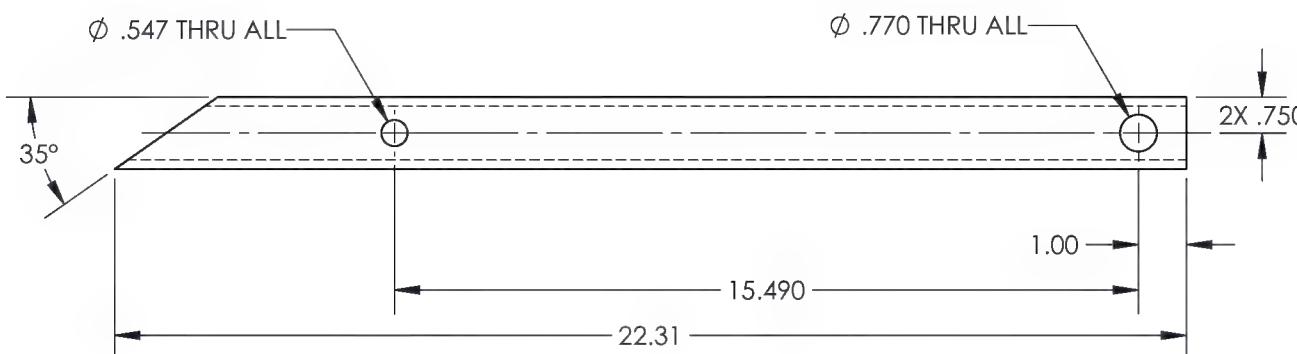
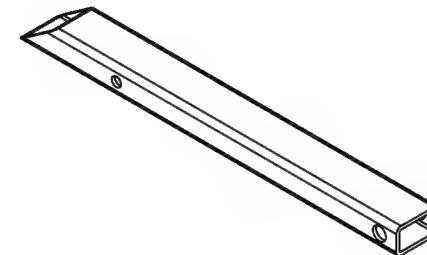
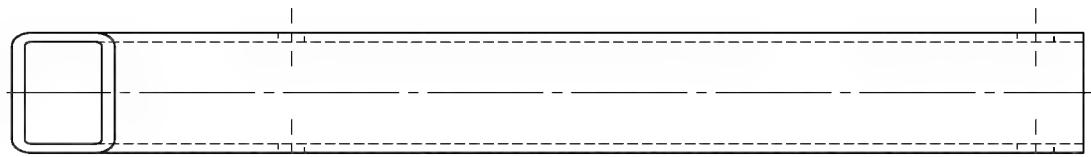
TUBE B

(39)

 MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-39
REV	2
MAT'L	A500
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -35	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:4
DATE	5/13/2016
SHEET	21 OF 31

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2			16-0221			-41 CH'D MAT'L FROM A36/1018/1020 HR TO A500.			11/15/2016			DPD			JAG		



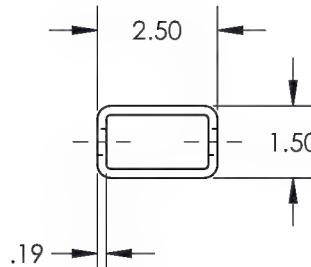
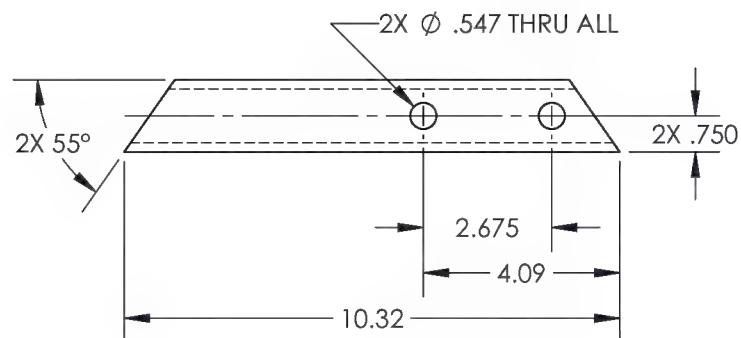
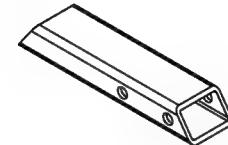
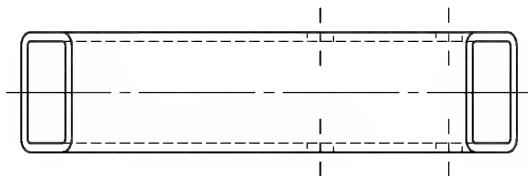
(-41)

TUBE C

TITLE		DART	
		AEROSPACE	
MAIN ROTOR HEAD SLING		REV 2	
DWG NO.		RBEM622U1005103-41	
MATERIAL		A500	
HEAT		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.000 ± .010 FRACTIONS ± 1/8	
SEE -35		.000 ± .03 ANGLES ± 1°	
SPEC		.000 ± .1 SURFACES = 125	
DRAWN BY:		CLOUGH	
CHECKED:		MACKOVJAK	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
USED ON MODEL		H175	
SCALE 1:4		DATE 5/13/2016	
SHEET 22 OF 31			

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REV			ECR			DESCRIPTION			DATE			INITIAL			APPROVED		
2	16-0221		-43 CH'D MAT'L WAS A36/1018/1020 HR IS A500.						11/15/2016			DPD			JAG		



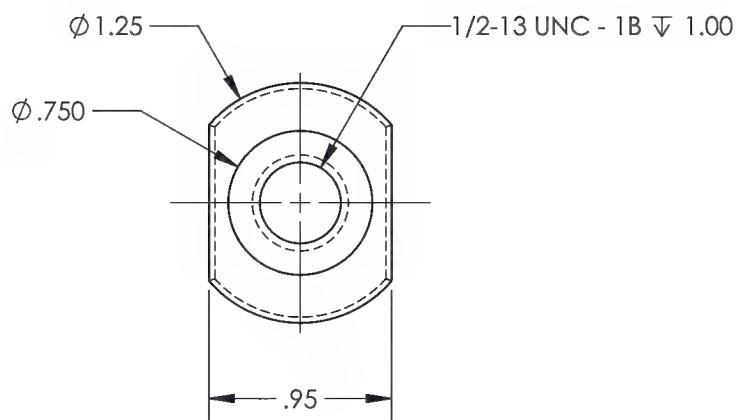
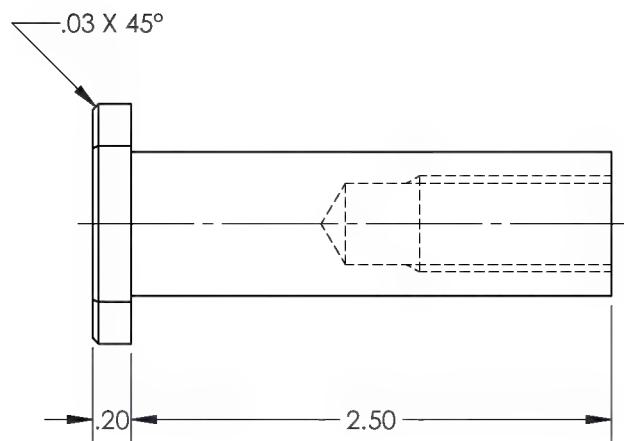
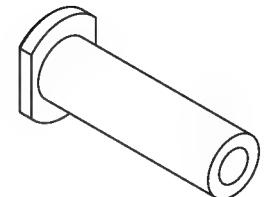
(-43)

TUBE D

	
TITLE	MAIN ROTOR HEAD SLING
DWG NO.	RBEM622U1005103-43
REV	2
MAT'L	A500
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SEE -35	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:4
DATE	5/13/2016
SHEET	23 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



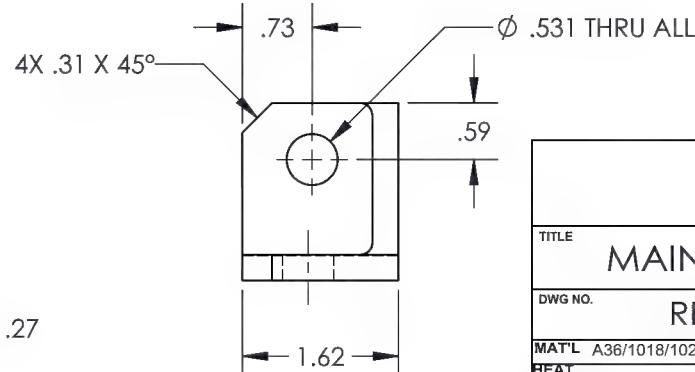
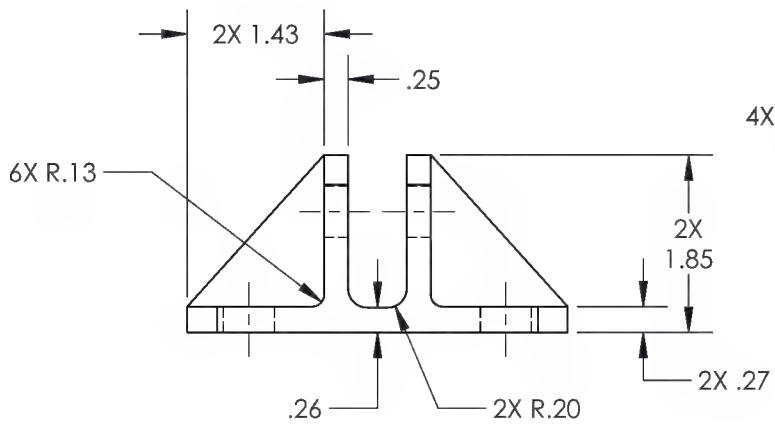
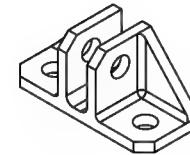
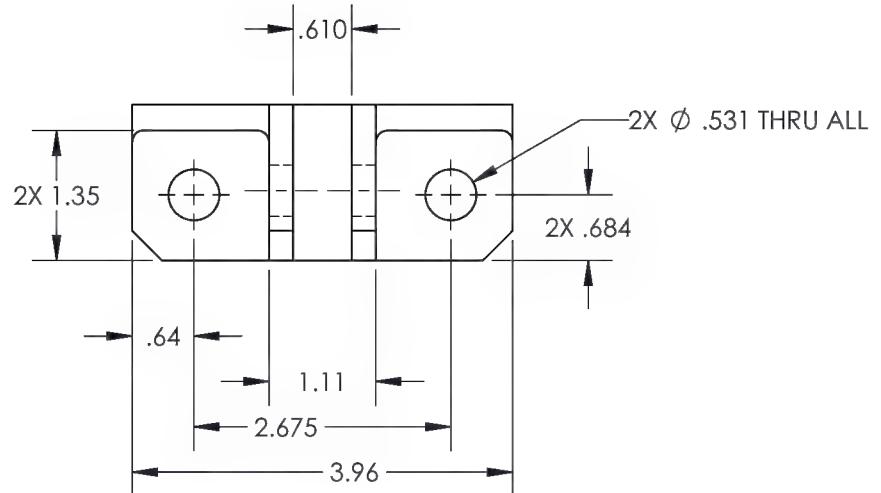
-45

BLUSHING

			
TITLE MAIN ROTOR HEAD SLING			
DWG NO. RBEM622U1005103-45			REV 2
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		$XXX \pm .005$ FRACTIONS $\pm 1/8$	
FINISH ZINC PLATE		$XX \pm .01$ ANGLES $\pm .5^\circ$	
SPEC ASTM B633 TYPE I SC 2		$X \pm .1$ SURFACES = 125	
DRAWN BY: CLOUGH		1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ OR $.015R$	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE	1:1	DATE	5/13/2016
			SHEET 24 OF 31

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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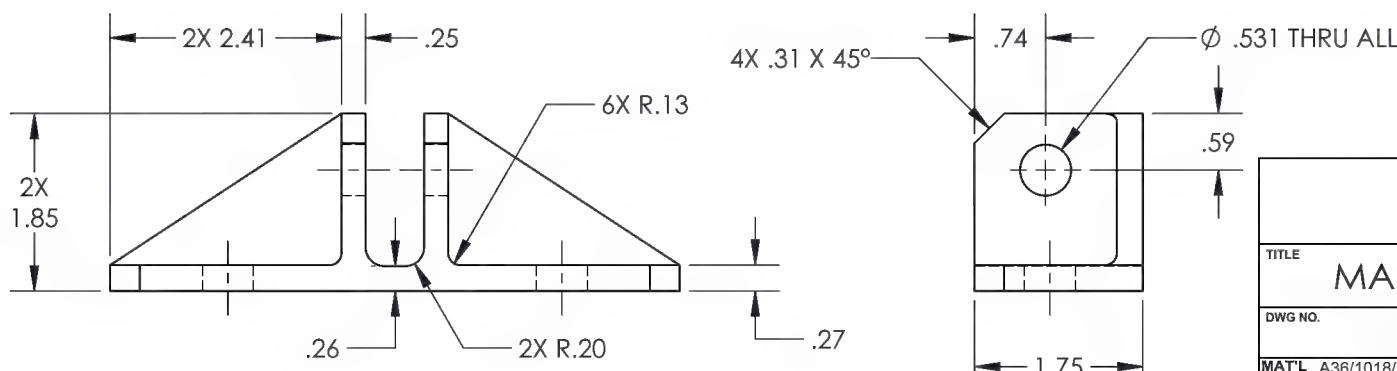
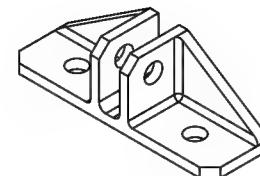
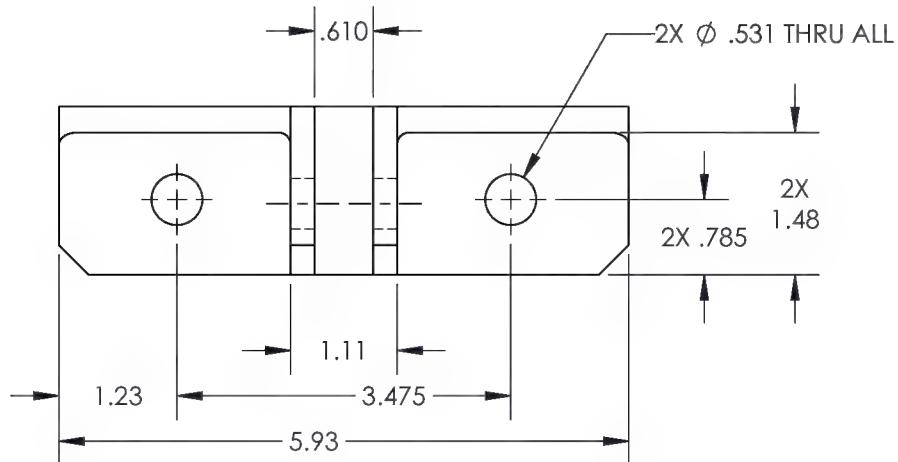
SMALL MOUNT BRACKET

(-47)

DART AEROSPACE	
TITLE	MAIN ROTOR HEAD SLING
DWG NO.	RBEM622U1005103-47
REV	2
MAT'L	A36/1018/1020 HR
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	.X ± .1 SURFACES = 125
SPEC	FED #13538 ✓
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	5/13/2016
SHEET	25 OF 31

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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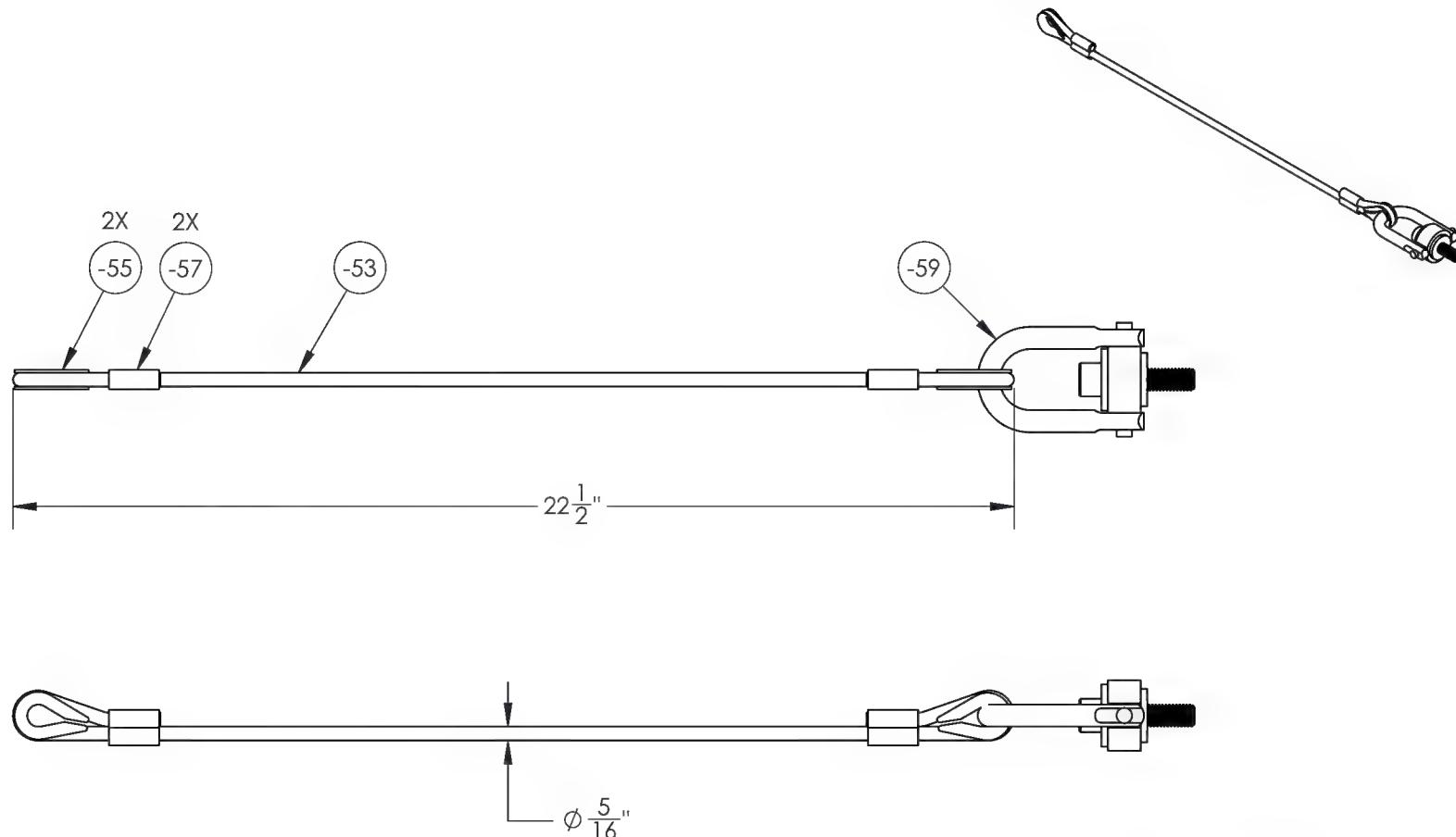
LONG MOUNT BRACKET

-49

DART AEROSPACE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-49
REV	2
MAT'L	A36/1018/1020 HR
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125 ✓
FED #13538	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:2
DATE	5/13/2016
SHEET	26 OF 31

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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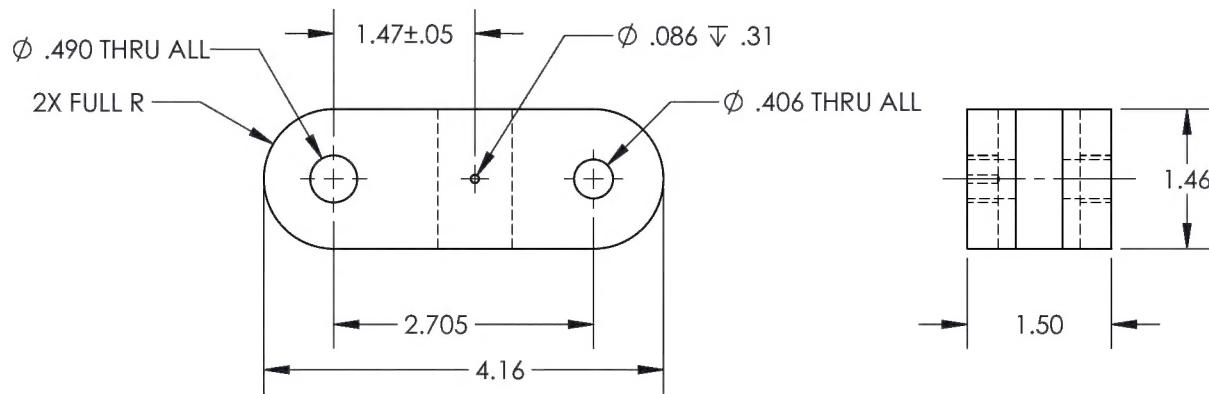
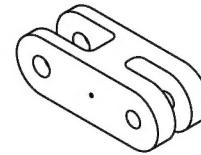
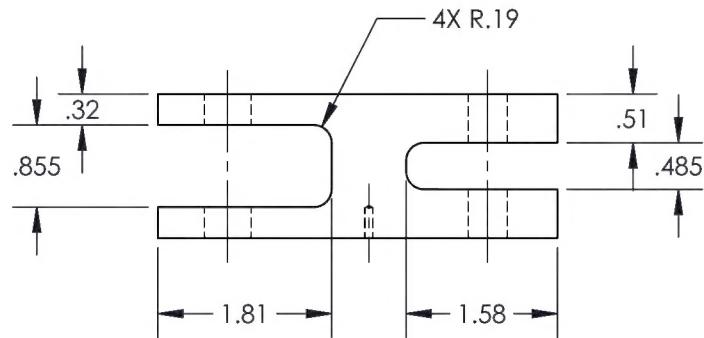
CABLE ASSEMBLY

(-51)

DART AEROSPACE	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-51	
REV 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:4
DATE	5/13/2016
SHEET 27 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-61 CH'D MAT'L WAS 1018/1020 CR IS 4140/4142. ADDED DIM 1.47±.05. CH'D DIMS WAS .508 IS .51, WAS Ø.095-.098 Ø.15 IS Ø.086 Ø.31.	11/15/2016	DPD	JAG



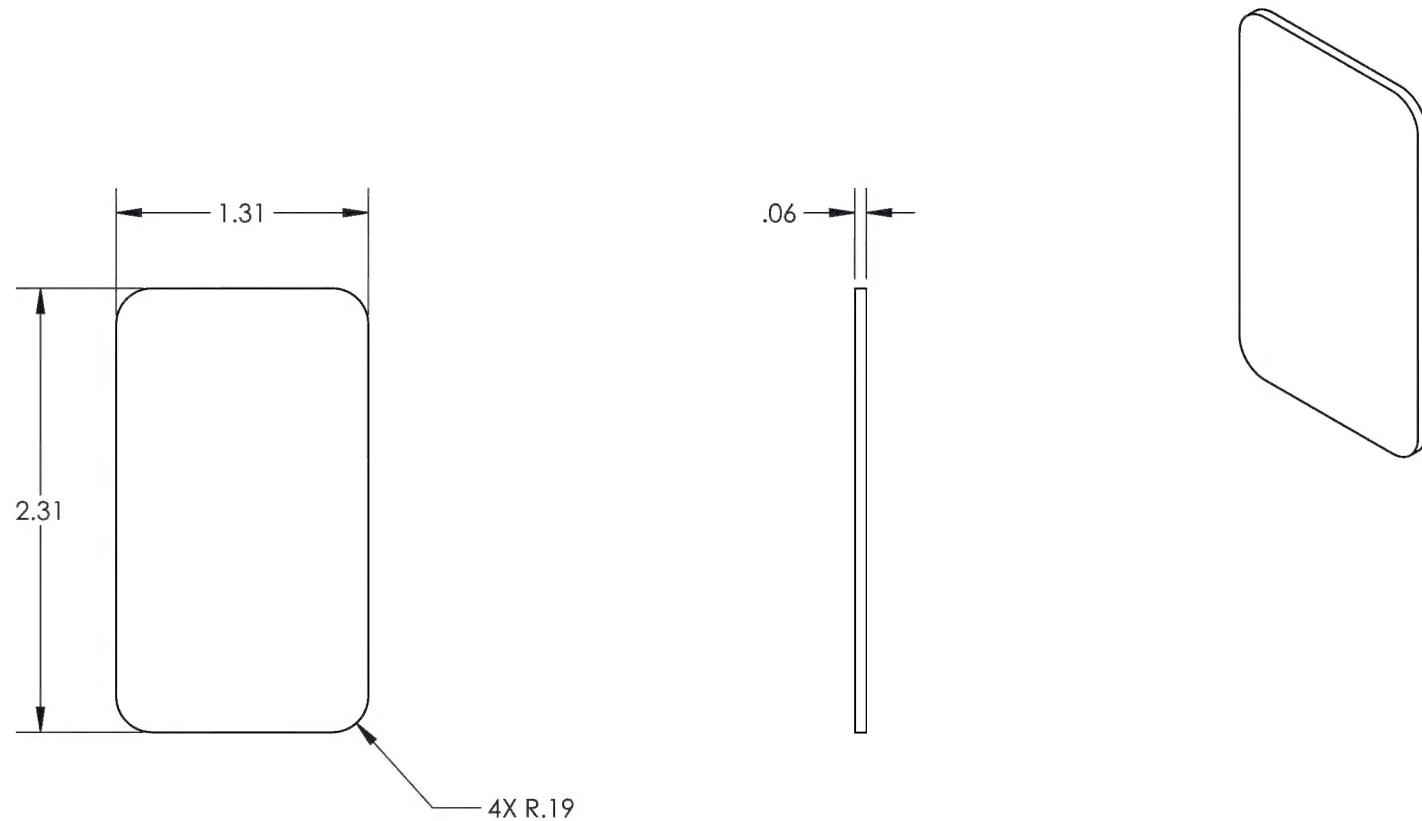
-61

LINK

TITLE		DART AEROSPACE	
MAIN ROTOR HEAD SLING			
DWG NO.		RBEM622U1005103-61	
REV		2	
MATERIAL		4140/4142	
HEAT		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		.X ± .1 SURFACES = 125 ✓	
CHECKED:		1. BREAK ALL SHARP EDGES	
OPPS APPR:		.015 x 45° OR .015R	
QA APPR:		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
SCALE		1:2	DATE
DATE		5/13/2016	SHEET 28 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-109 ADDED DRAWING. CH'D MAT'L WAS POLYETHYLENE IS A36/1018/1020 HR. WAS B/O IS MANUFACTURED.	1/3/2017	DPD	JAG



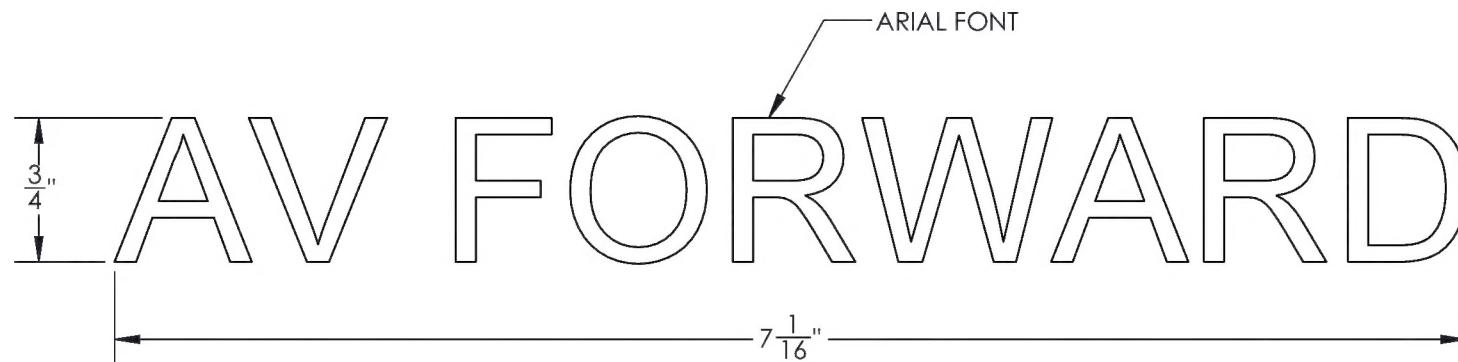
-109

TUBE CAP

	
TITLE	
MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103-109
REV	2
MATERIAL A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -35	X ± .1 SURFACES = 125
SPEC	✓
DRAWN BY:	CLOUGH
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
H175	
SCALE	1:1
DATE	5/13/2016
SHEET 29 OF 31	

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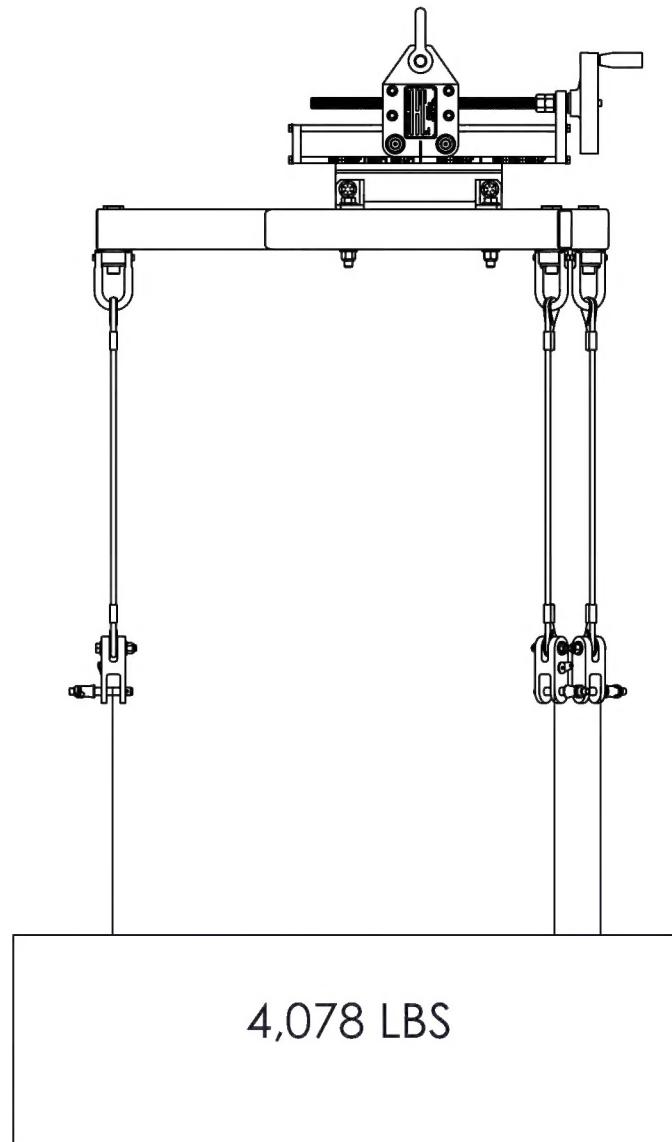
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-125 ADDED TO BOM QTY: 1. ADDED DRAWING.	1/4/2017	DPD	JAG



-125

DECAL

	
TITLE	
DWG NO.	MAIN ROTOR HEAD SLING
	RBEM622U1005103-125
REV	2
MAT'L	BLACK VINYL
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
DRAWN BY:	DUERFELDT
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:1
DATE	1/4/2017
SHEET 30 OF 31	



INSPECTION & TESTING PROCEDURES FOR THE
RBEM622U105103, MAIN ROTOR HEAD SLING.

- INSPECT THIS ASSEMBLY BEFORE EACH USE.
- REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, ATTACH SLING ASSEMBLY TO AN OVERHEAD LIFTING DEVICE.
2. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 4,078 LBS. ADJUST THE POSITION OF THE SLING IF NECESSARY TO ENSURE THAT THE SLING REMAINS LEVEL.
3. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
4. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR: _____

TESTER: _____

S/N: _____

DATE: _____

DART
AEROSPACE

190 S. Danebo Ave., Eugene, OR. 97402

1-800-556-4166

e-mail: sales@dartaero.com
dartaerospace.com

TITLE		MAIN ROTOR HEAD SLING	
DWG NO.	RBEM622U1005103	REV	2
SCALE	1:12	DATE	5/13/2016
SHEET	31 OF 31		